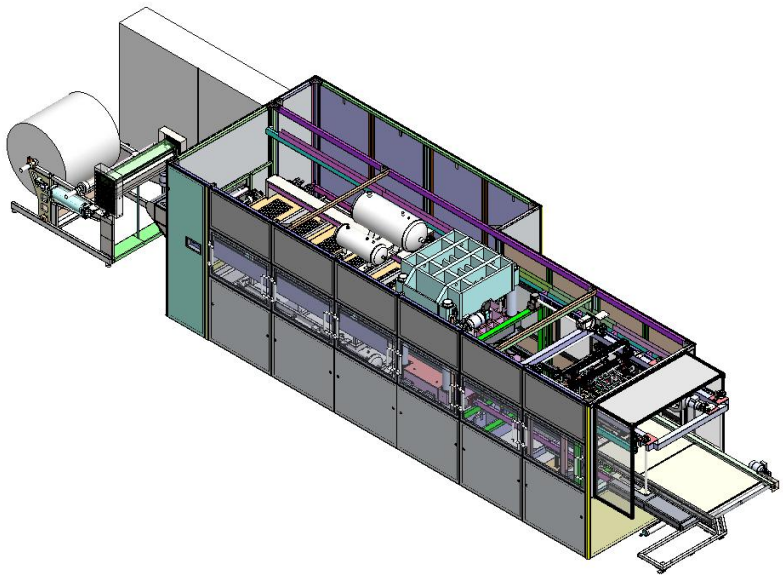


YM9005/2
TWO STATION THERMOFORMING MACHINE

2013

INDEX

1.1 INTRODUCTION 7

1.2 GUARANTEES AND ASSURANCE 9

1.3 TECHNICAL SUPPORT 10

2.1 SAFETY PRECAUTIONS 12

2.2 LABELS AND THE MEANING OF SYMBOLS 14

2.3 WARNINGS 16

3.1 MACHINE TRANSPORT 19

4.1 MACHINE GENERAL INFORMATION 23

4.2 USED EQUIPMENT AND FEEDING PLATE 24

4.3 TECHNICAL SPECIFICATIONS 25

4.4 MACHINE PARTS 26

4.4.1 ROLL-UP AND SUPPLY UNIT (A) 27

4.4.2 CHAIN SYSTEM (B) 28

4.4.3 HEATING UNIT (C) 29

4.4.4 FORMING UNIT (D) 30

4.4.5 STACKING UNIT (F) 31

4.4.6 THE WASTE MATERIAL ROLLING UNIT (H) 32

4.4.7 CONTROL PANEL (I) 33

4.4.8 ELECTRICAL BOARD CABINET (J) 34

4.4.9 AUTOMATIC LUBRICATION UNIT (K) 35

4.5 MOULD DIMENSIONS 36

5.1 INSTALLATION AND FIRST START 38

5.1.1 CONTROLLING THE MACHINE BEFORE OPERATING IT 38

5.1.2 THE FEEDING CONNECTIONS 39

5.1.3 THE MOULD CONNECTIONS 40

5.1.4 THE CUTTING EQUIPMENT CONNECTIONS 40

5.1.5 THE MECHANICAL SETTINGS OF THE MACHINE 41

6.1 SCREEN MENU 43

6.1.1 CYCLE 44

6.1.2 HEAT CONTROL 47

6.1.3 CHAIN SERVO SETTINGS 50

6.1.4 FORMING ADJUSTMENT 1 52

6.1.5 FORMING ADJUSTMENT 2 54

6.1.6 CUTTING ADJUSTMENT 1 55

6.1.7 STACKING ADJUSTMENT 1 56

6.1.8 STACKING ADJUSTMENT 2 58

6.1.9 ROBOT ADJUSTMENTS 59

6.1.10 SWEEP ADJUSTMENTS 60

6.1.11 SELECTIONS 61

6.1.12 MANUAL CONTROL 62

6.1.13 STRECHING 63

6.1.14 WORKING PAGE 64

6.1.15 USER LEVEL ADJUSTMENT 65

6.1.16 SPEED GRAPH 67

6.1.17 DIGITAL INPUT AND OUTPUT PAGES 68

6.1.18 OTHER ADJUSTMENT 1 69

6.1.19 OTHER ADJUSTMENT 2 70

6.1.20 ALARM PAGE 72

6.1.21 RECIPES 73

6.1.22 RECIPES 2 75

7.1 BEFORE MAINTENANCE 82

7.2 DAILY MAINTENANCE 82

7.3 WEEKLY MAINTENANCE 82

7.4 MONTHLY MAINTENANCE 83

7.5 YEARLY MAINTENANCE 83

7.6 AFTER MAINTENANCE 83

7.7 MAINTENANCE PLAN 84

7.8 CONSUMABLES GIVEN WITH MACHINE 85

8.1 MALFUNCTIONS AND SOLUTIONS 87

9.1 WASTE MATERIAL DISPOSAL 95

10.1 SPARE PARTS AND TECHNICAL SUPPORT PROCEDURE 97

10.2 FORMING SPARE PARTS LIST 98

10.3 STACKING SPARE PARTS LIST 108

10.4 ROBOT STACKING SPARE PARTS LIST 111

10.5 STRETCHING SPARE PARTS LIST 115

10.6 CHAIN SPARE PARTS LIST 116

10.7 HEATER HEAT SPARE PARTS LIST 121

10.8 WRAPPER SPARE PARTS LIST 124

10.9 UNWINDER SPARE PARTS LİST 125

CHAPTER 1

1. INTRODUCTION

1.1 INTRODUCTION

This booklet contains information on how to operate YENIYURT thermoforming machine,

- regulations on maintenance and operation
- points to consider while transporting and shipping
- warnings on dangerous or harmful conditions on human and nature in use
- information on misuse of the machine,
- introductory and basic information on the machine,
- how to assemble the machine.

Please read and follow the instructions provided in this booklet first to provide a safe environment for the operators and to keep the machine operating and keep this booklet permanently.

All the consequences stemming from the operations which are not included in this booklet will belong to the user.

This booklet includes all the information on Yeniyurt Machine models mentioned below. The points changing model by model are stated by references according to the model names, in this booklet:

- Yeniyurt Machine YM 8060 Three Station Thermoforming Machine
- Yeniyurt Machine YM 8060 Four Station Thermoforming Machine

PLEASE READ CAREFULLY THIS BOOKLET AND FOLLOW THE INSTRUCTIONS BEFORE OPERATING THIS MACHINE

THE OPERATORS AND TECHNICAL EMPLOYEES MUST READ AND UNDERSTAND ALL THE INFORMATION PROVIDED IN THIS BOOKLET

ALL THE DOCUMENTS RELATED TO THE MACHINE ARE PROVIDED TO YOU WITH THIS MACHINE, PLEASE READ ALL

1.2 GUARANTEES and ASSURANCE

Yeniyurt Machine, from the sale of the product under warranty during the first 12 months of services. The machine will be the first to install and operate free of charge by Yeniyurt Machinery. The warranty covers parts of fault conditions and should be replaced under warranty. Except for services covered by this warranty, the customer company can not claim any other contract, user errors that may occur on the machine and the external factor can not claim the cost of other damaged and can not cancel the sale.

For warranty parts and service changes are made where the machine is installed according to the technical service personnel and legal laws company meets the customer the cost of all transportation and accommodation.

As long as the customer uses the company according to the information specified in the user guide of the machine under warranty service may demand. In addition, external factors arising from the operator or master shall be charged to all services not covered by warranty.

In cases of machine malfunction, the user can be solved outside the owner's manual instructions all the cases, no one other than authorized service Yeniyurt machine must not interfere with the machine. Otherwise, the results of all actions arising out of warranty will remain.

1.3 TECHNICAL SUPPORT

The order of the technical services will be determined according to the arrival date and hour of the demands of the service-calling customer firms.

In case of a malfunction, the customer firm must contact with Yeniyurt Machine via the phone number, fax number or internet by using the information provided below directly:

Yeniyurt Machinery Industry and Trade Co.

Address: Abdi İpekci Cad. Zorlu Sk. No:10
Bayrampasa Istanbul/TURKEY

Tel: +90 212 565 44 91
Fax: +90 212 613 22 25
web: www.yeniyurt.com

e-mail: info@yeniyurt.com

CHAPTER 2

2. SAFETY & ACCIDENT PREVENTATION

2.1 SAFETY PRECAUTIONS

1- The machine must not be operated without reading the user guide.

2- Protection and safety parts should not be removed and partially operated. Otherwise, serious injury or damage can occur.

3- There are safety switches on all doors and gates of the machine and the machine stops by turning to safety status when any door or gate is open. For safety reasons, any of these switches should not be cancelled or the machine should not be operated when any cover or door is open, no matter what the reason is.

4- Because plastic sheets used contain flammable materials and there exist resistances working with high heat, precautions should be taken against fire. The machine must be kept near the fire extinguisher.

5- Before pouring any liquid on the machine for extinguishing purpose in case of a fire threat, all the main circuit must be turned off from the main switch. Otherwise, an electric shock can occur.

6- Machine lubrication and maintenance operations should not be done while the machine is operating.

7- A switch is mounted to the machine guards for safety purposes. The guards of the machine should not be closed for any reasons, when somebody is in the machine.

8- Before the machine operates, working and technical safety precautions should be taken and the vicinity of the machine should be controlled.

9- The lubrication and maintenance done after the stop the operation of the machine, the protectors of the machine must be worn. The machine must not be

operated without these protectors. In the area of the operation of the machine, the warning signs must be followed.

10- The machine in operation must not be intervened with hand or any other material, with no reason.

11- In case of a breakdown or disruption, people in charge and relevant should be informed. People without any information or technical training must not interfere with the machine.

12- While loading sheet coil to the sheet feeding and the pneumatic lifting system is on, no one must be near the feeding unit apart from the employee controlling the system.

13- The key must not be left on the emergency stop button which is on the operating panel of the machine.

14- It is obligatory to build electrical grounding system on the machine.

15- During maintenance, setting or change of mould, the machine must be suspended by using the emergency stop button on the control panel and the lock on the emergency stop button must be locked with the key and the key must be kept only by the person in charge for maintaining, setting or changing the mould.

16- The warning signs on the machine must be given importance to and the written warnings must be followed. The signs must not be removed or damaged.

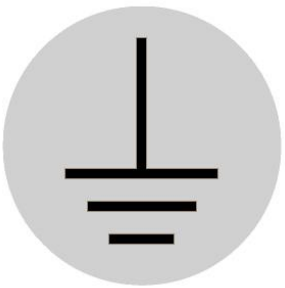
17- The room where the machine operates must be lightened and ventilated well enough for health conditions. When the needed conditions are not supplied, it is possible to be happen accidents due to loss of attention.

2.2 LABELS AND THE MEANING OF SYMBOLS

DANGER	Warnings could result in serious injury or death.
WARNING	Warnings that could result injuries or could damage the machine parts.
	Any intervention must not interfere with anyone other than authorized persons when needed.
	Automatically moving the machine while it is running by itself, no one under the systems should not have.
	Automatically moving the machine while it is running by itself should not have anyone on the systems.
	Systems that automatically moving the machine while it is running by itself should not interfere in any way.
	High temperatures from the surface to touch may cause second degree burns.
	Don’t touch rollers while the machine is running.
	Don’t move on the machine while it is running.
	Grounding is not made of static electricity can build up and static electricity can cause serious damage to people with heart disease.
	Lubricate not required sections.

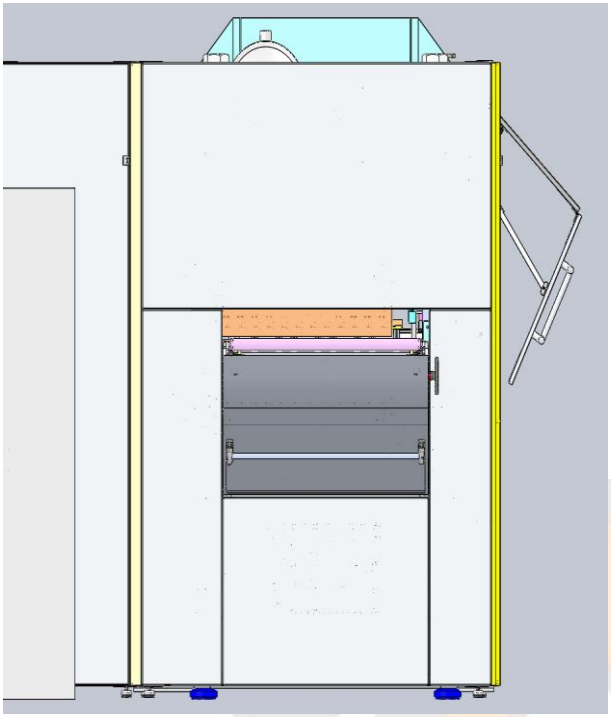
	Automatically when the self-moving and running gear system should not intervene.
	Pressed on the machine are the parts may be damaged. Don't step on these parts.
	There is high-voltage equipment in the running. Should not interfere with electrical interruption.
	Automatically moving the machine while the cutter is running. Certainly should not interfere with the machine until stopped.
	There is sharp-edged track. Adjustment and maintenance should be made carefully; otherwise they can cause deep cuts.

Grounding Warning

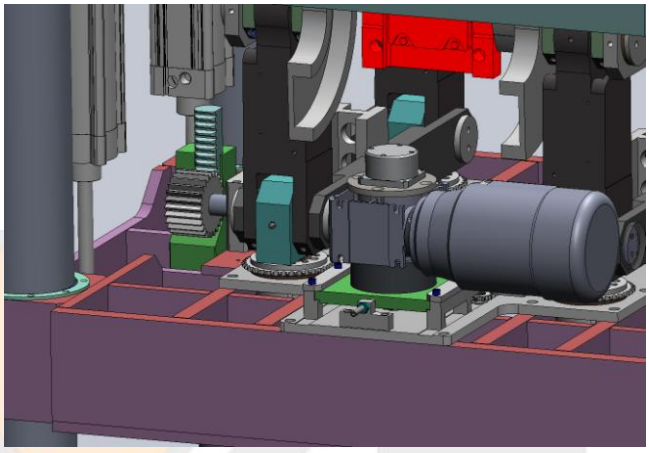


Power leakage from the machine could lead to current leakage that is why grounding should be done to avoid the danger of electric shock. Machines, electronic components: a high risk of damage to the grounding without addition. Gas pipes, telephone lines or other potential arc can not be used for earth roads. Improper grounding can cause electric shock.

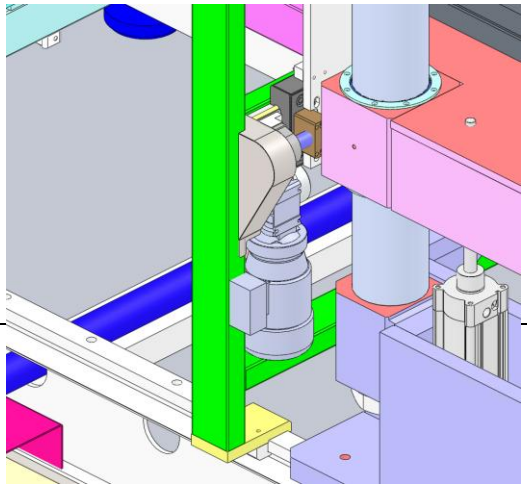
2.3 WARNINGS



The employees must be out of the area shown in the photograph beside, because a shearing effect is caused when the covers are closed.



When moulding settings are done on the machine, a threat for chain grabbing occurs. Due to this, the employees must be kept away and the operator should be careful during this process.

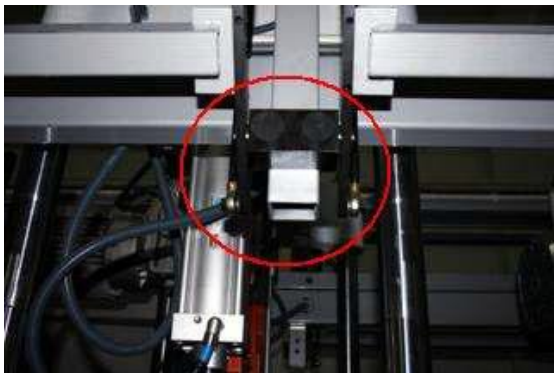


When the sheet width is adjusted, the chain demonstrated in the photograph move. In this case, it can cause damage

injuries by grabbing the cloths of the employees or other materials. Thus, protecting covers of the chains must be removed during adjustment, the employees must stand away from this area and the one controlling the process should be completely careful.

When the chain sled engine on the machine is operating, the gears situated on the chain as demonstrated in the photograph can cause damage to the uniforms of the employees or other materials by grabbing. Thus, the employees must stand away from this area and the one controlling the process should be completed carefully.

When the system is operating, the moulding system forming the product creates a danger for pulverization. Thus, when the machine is on process, one must not approach to the system.



When the guards of the machine are opened, the support column situated in the area between the two guards becomes dangerous. Staff must be careful while maintaining the machine, because it can cause serious injury if any employee hits his head.

CHAPTER 3

3. INSTALLATION & CARRIAGE

3.1 MACHINE TRANSPORT

The staff who will be in charge of transport process of the machine must be informed on the issue of transport and experienced enough to prevent any failure.

Depending on the transport distance and the demands of the customer, the transport process can be completed through highway or sea way. In the transportation of highway, all parts are packed properly.

The last users must control the machine when they receive it. All the parts needing carriage must be carried with suitable equipments according to their weights and features. Yeniyurt Machine does not accept any damage caused by improper transportation, transport and untrained staff.

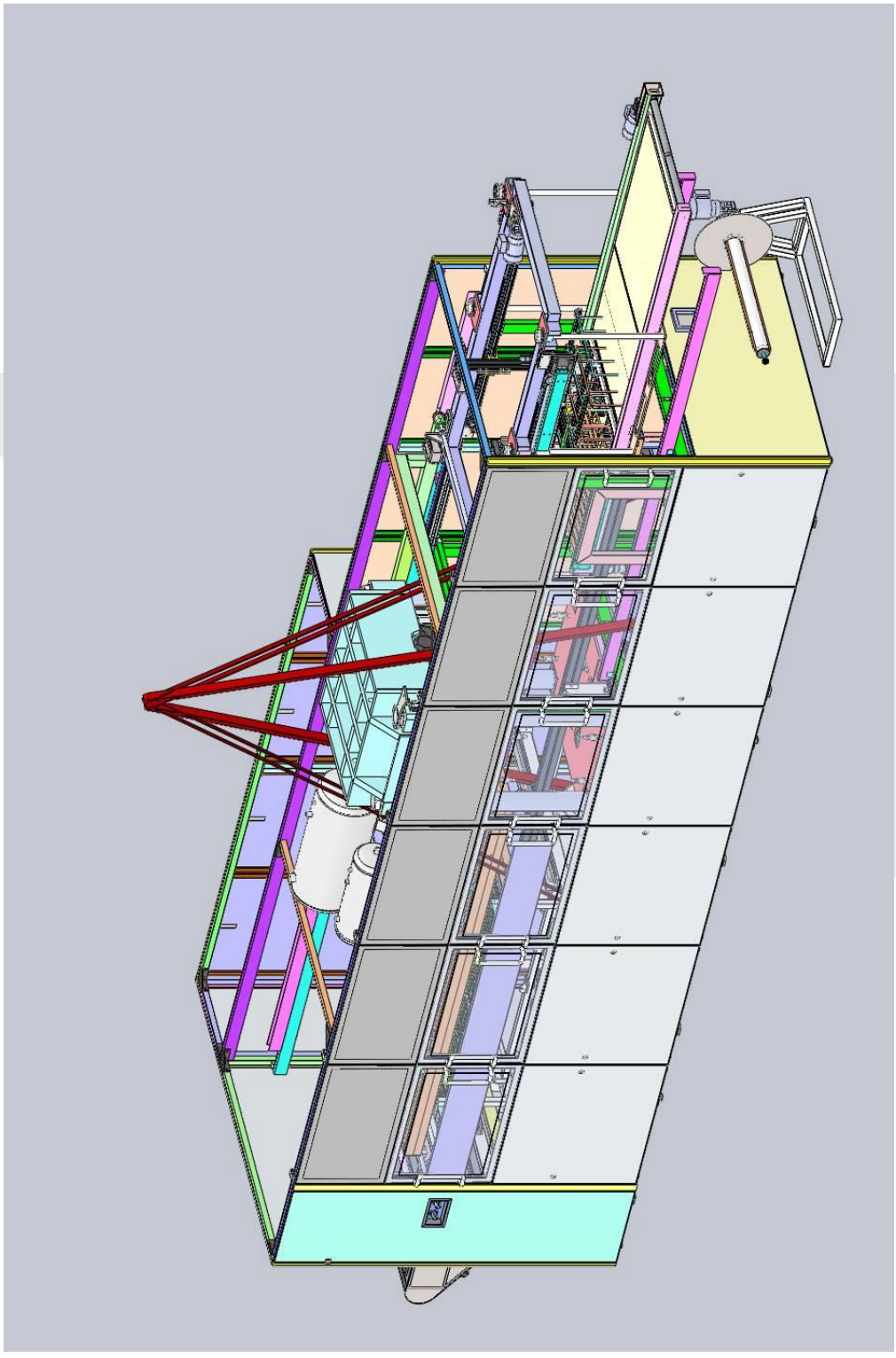
The possible damages caused by any strike of the machine to other objects can be prevented by putting wooden wedges to suitable places of the machine.

The cargo parts consist of three parts. Machine, electrical cabinet and feeding unit are packed separately.

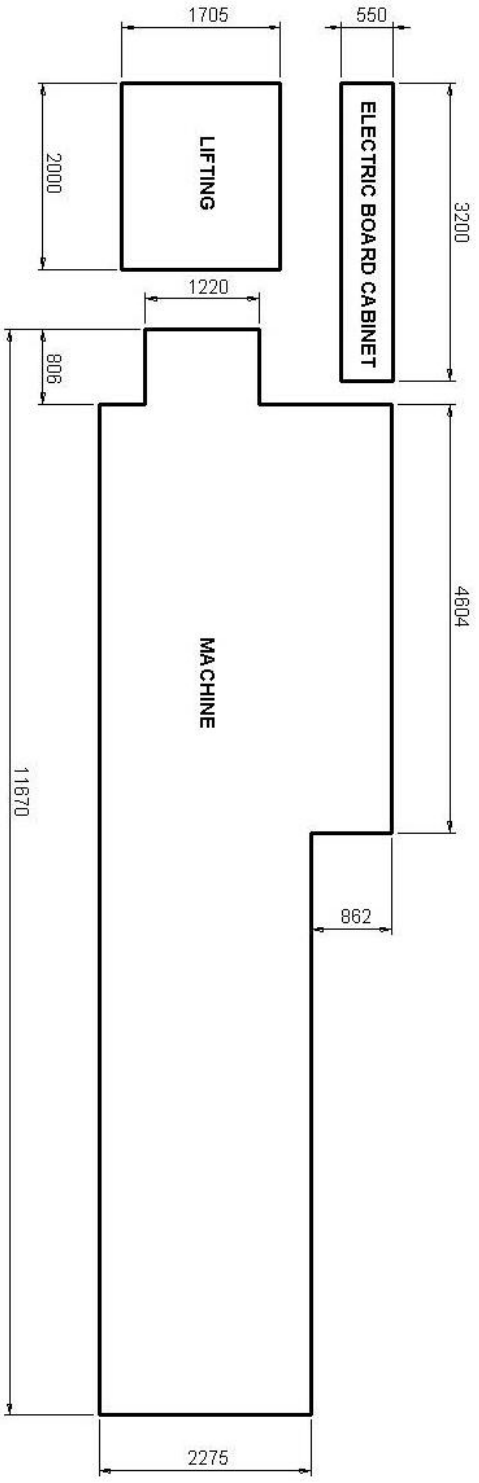
Adequate number of trained staff is needed throughout all the stages of transportation, storing and un-loading.

Lifting points of three station and four station thermoforming machine are shown at next figures.

Two Station Thermoforming Machine Lifting Points:



Two Station Thermoforming Machine Layout Plan:



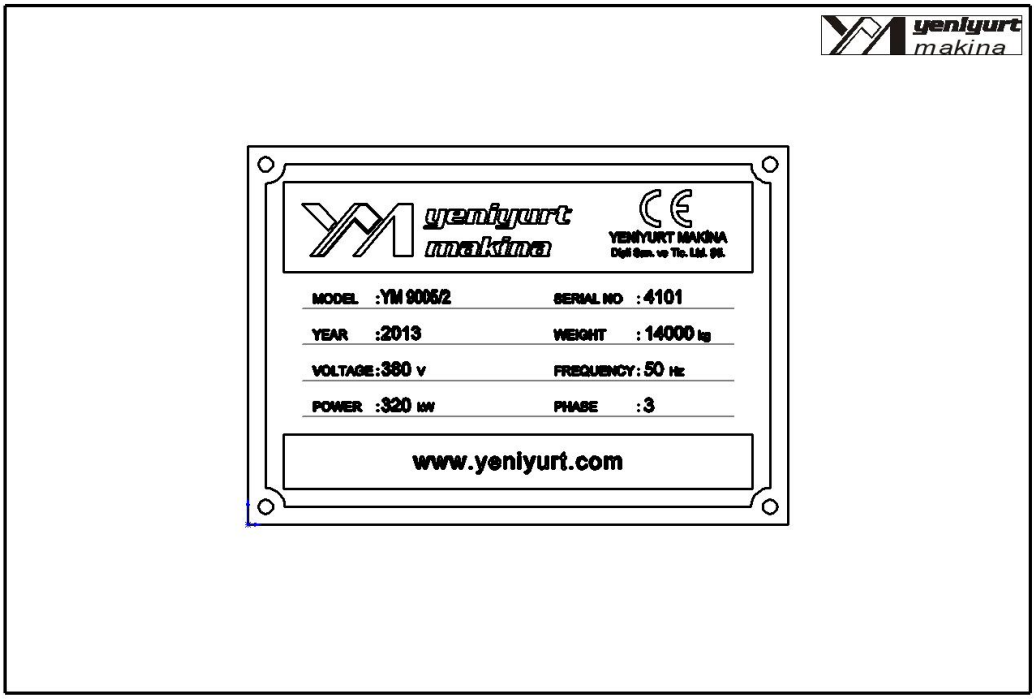
CHAPTER 4

4. MACHINE SPECIFICATIONS

4.1 MACHINE GENERAL INFORMATION

All the Yeniyurt Thermoforming Machine models are designed for the automatic production of disposable plastic food packing and packing for various sectors. They must not be used for any other purpose. Thermoforming machine gives the last product by heating, forming, punching, cutting and stacking the plastic thermoforming material. The technical features of the thermoforming plastic sheet materials are given in the section of “The Materials to Be Used and Sheet Feeding”.

The label containing the basic information and serial number is on the sheet intake facet on the thermoforming machine.

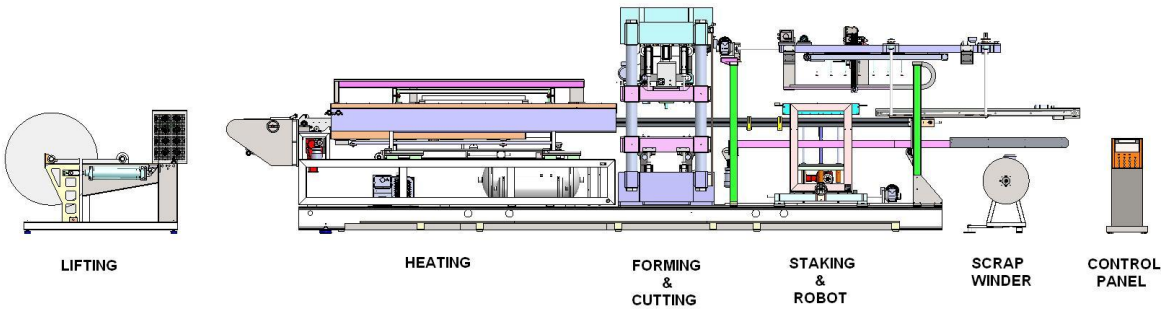


Sample Label of YM9005/2

4.2 USED EQUIPMENT AND FEEDING PLATE

Yeniyurt Thermoforming Machine can give the last product only with such materials PP, PS, Pet, PVC and other suitable materials.

In the case of use of any other material other than stated above, the customer firm is regarded as not obeying the user instructions. The other materials can be only used if Yeniyurt Machine tests and confirms them. Sheet feeding unit provides the intake of the previously stated materials in the roll form. With the help of sheet feeding unit, the material is transmitted first to the heating station, then forming/cutting station and finally to the stacking station via chain sled system. After the stacking station, the last product comes out of the machine and the waste material waste material is rolled in the wastage rolling unit.



4.3 TECHNICAL SPECIFICATIONS

	YM9005/2 **Tuo Station** **Thermoforming Machine**
Maximum Mould Size	1000x1250mm
Maximum Forming Area	960x1210 mm
Maximum Cutting Area	960x1210 mm
Positive Forming Height	50 mm
Negative Forming Depth	80 mm
Maximum Sheet Width	1050 mm
Minimum Sheet Width	600 mm
Upper Heater Heating Power	155 kW
Lower Heater Heating Power	99 kW
Continuous Power Consumption	130 kW
Total İnstalled Power	320kW
Vacuum	205 m^3/h
Dry Running Cycle	40 cycle/min
Weight (approx.)	14000 kg
Length	11500 mm
Width	3140 mm
Height	2950 mm
Required Compressor	10 m^3/min
Required Cooler	30000 kcal/hour

4.4 MACHINE PARTS

Machine mainly consists of these parts: (Figure 4.4.a)

A- Roll Taking-in and Feeding Unit

B- Chain Sled

C- Heating Unit

D- Forming Unit and Cutting Unit

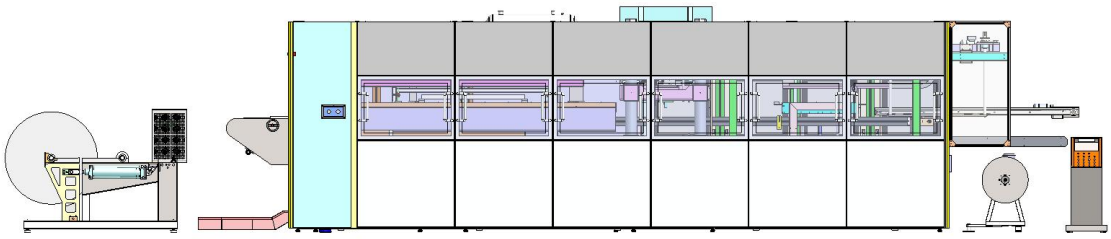
G- Stacking Unit

H- Waste Material Rolling Unit

İ- Control Panel

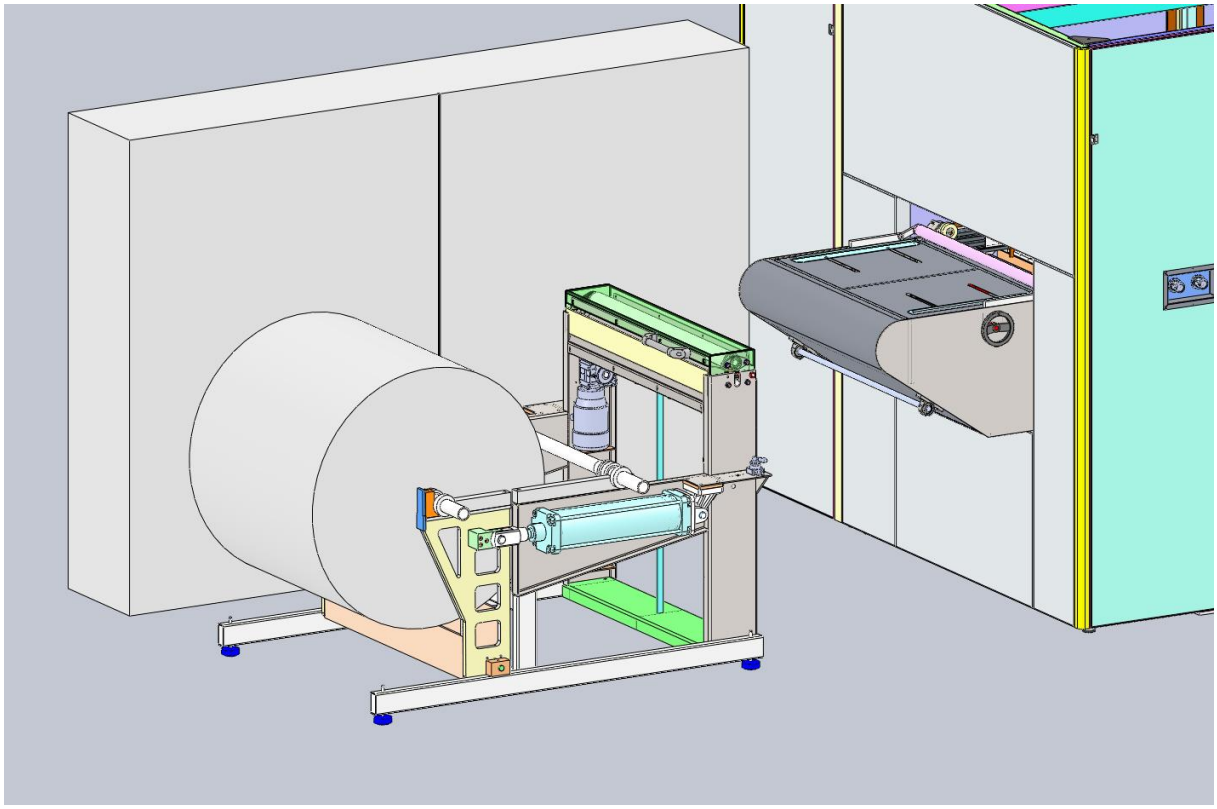
J- Electric Board Cabinet

K- Automatic Lubrication Unit



4.4.1 ROLL-UP and SUPPLY UNIT (A)

The roll taking-in unit functions to load the rolled material to the feeding unit via two pistols (Picture 4.4.1.a). The process is realized with the button. The diameter of the material to be loaded to the feeding unit must be maximum 1100mm, minimum 300mm.



4.4.2 CHAIN SYSTEM (B)

With the chain sled system, the automatic movement of the sheet is provided by putting the sheet material automatically to the continuously moving gears of the chain from two sides. Right before opening of the sheet material from the roll in the feeding unit is put onto the chain sled, there exists a centering system at the head of the machine. Via the handle in this system, the width of the metal sheet is adjusted according to the sheet material and centering is settled in this way. The cooling water circulates in the chain sled system and the overheating of the chain is prevented.

4.4.3 HEATING UNIT (C)

The sheet material comes to the heating unit via the chain with gears. There are two pieces of heaters at the opposite sides of each other. These heating units constitute with infrared ceramic resistances. At the same time, both resistances have thermocouple resistances to control the heating level. The heating settings of the heaters can be controlled with the control panel. Both heaters consist of 1000W, 650W and 500W, both thermocouple and non-thermocouple resistances.

The system carrying the heaters is railway system. Via one pneumatic piston, the heaters are taken into the machine. At the same time, the heating system can be controlled manually with a handle.

4.4.4 FORMING UNIT (D)

Heated sheet that comes from heating oven goes to forming station by guiding chains. Sheet takes its first form inside the upper and lower forming blocks by help of pressured air and/or vacuum. The movement of forming blocks is obtained with servo motors that placed at upper and lower side of the forming station.

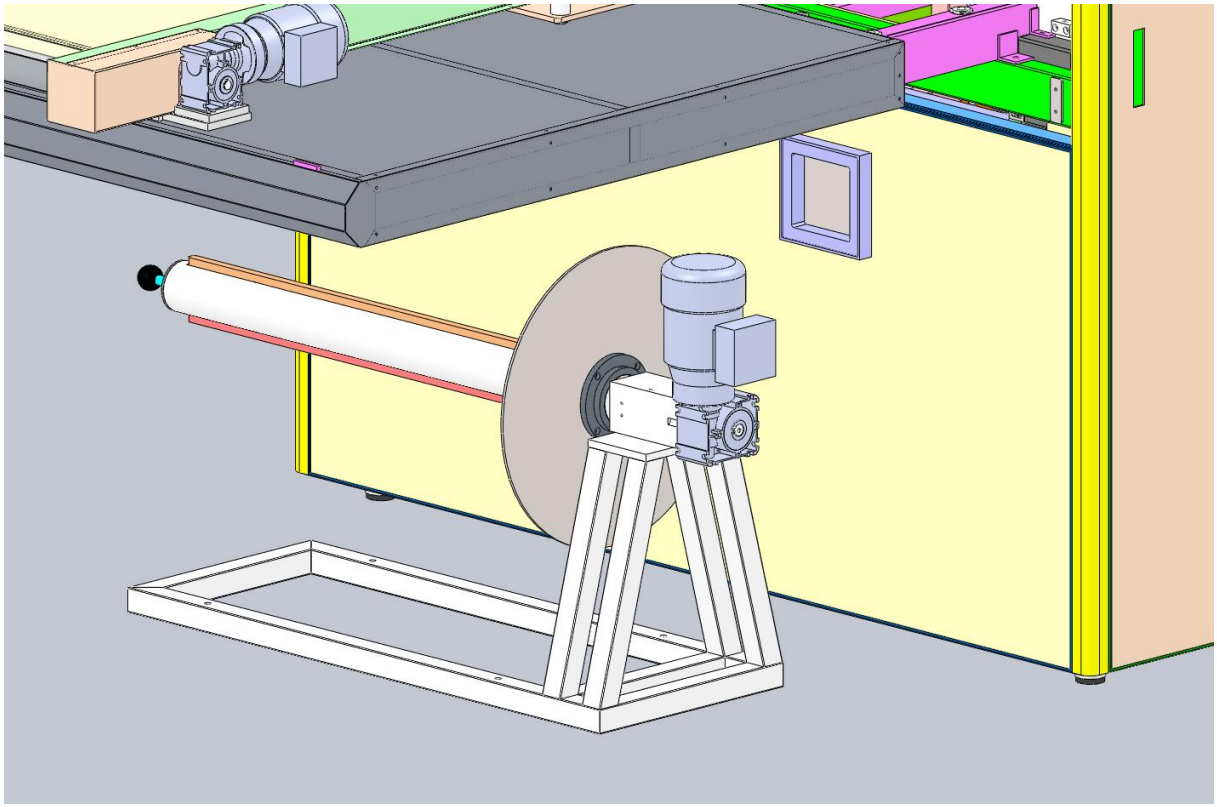
4.4.5 STACKING UNIT (F)

After the shape is given with the forming station, the product at the cutting station is not separated from the sheet material totally. The product is cut from the sheet with slight connection points. The products separated from the sheet with the pushing force are stacked according to the numbers submitted to the control panel and the stacked products are put out of the platform.

The stacking unit has two types with options. Though the machine is the same in total, only the stacking unit can show difference. In the option stacking from the bottom to the top, the stacking starts from the bottom and come out of the platform on the top. In the option of stacking from the top to the bottom, the stacking is done from top to the bottom and the completed product comes out of the platform at the bottom.

4.4.6 THE WASTE MATERIAL ROLLING UNIT (H)

The waste material remaining from the finished product is rolled with the help of the waste material rolling unit. When the first waste sheet reaches to the rolling unit, it must be rotated to the waste material rolling shaft manually. At the same manner, the waste material must be taken from the roll by cutting, when it is full and the tip of the coming waste material must be rotated manually once more.



For the instructions to eliminate the rolled up material, please read the part “Waste Material Disposal”.

4.4.7 CONTROL PANEL (I)

The control panel is the unit which all the settings and processes are done with a monitor and the buttons on it (Picture 4.4.9.a). All the processes that will be done with the monitor and buttons are explained in the part: “The Control Panel and Operating“

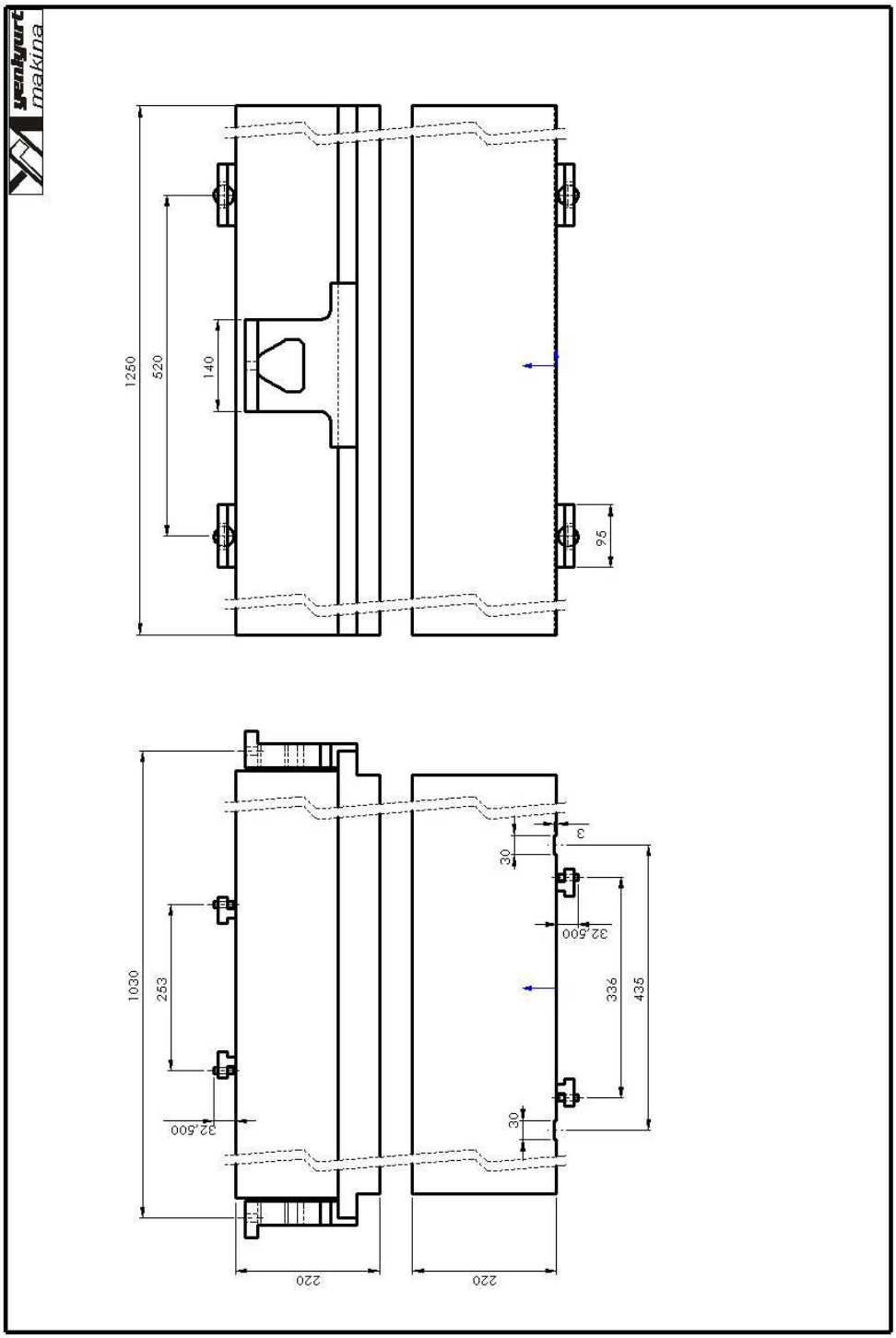
4.4.8 ELECTRICAL BOARD CABINET (J)

The electrical board cabinet is the unit to which all the electrical fitting and control panel is connected and include all the electrical hardware. Moreover, the electrical board cabinet has fans preventing overheating and dust. These fans need to be cleaned every 3 months and changed each year.

4.4.9 AUTOMATIC LUBRICATION UNIT (K)

The machine contains an automatic lubrication system on its own. With an oil pump and the lubrication fitting, all the equipments needing lubrication get lubricated.

4.5 MOULD DIMENSIONS



CHAPTER 5

5. FIRST START AND SETTINGS

5.1 INSTALLATION AND FIRST START

5.1.1 CONTROLLING THE MACHINE BEFORE OPERATING IT

Before operating the machine, it is obligatory to do some controlling:

* Control each connection in terms of regularity and that the protective equipment is closed.
* Control the pneumatic connections.
* Control the adequacy of the air pressure linked to the machine. (6 bar)
* Check the cooling system connections.
* Check the amount of the cooler liquid.
* Check all the surfaces needing lubrication.
* Check if the power supply is fully seated to the electrical panel.
* Check if the input voltage is sufficient.

Important: If all the engines operate backwards, replace the phases of the power supply in opposite. Before doing this, be sure that you cut all the electrical connections.

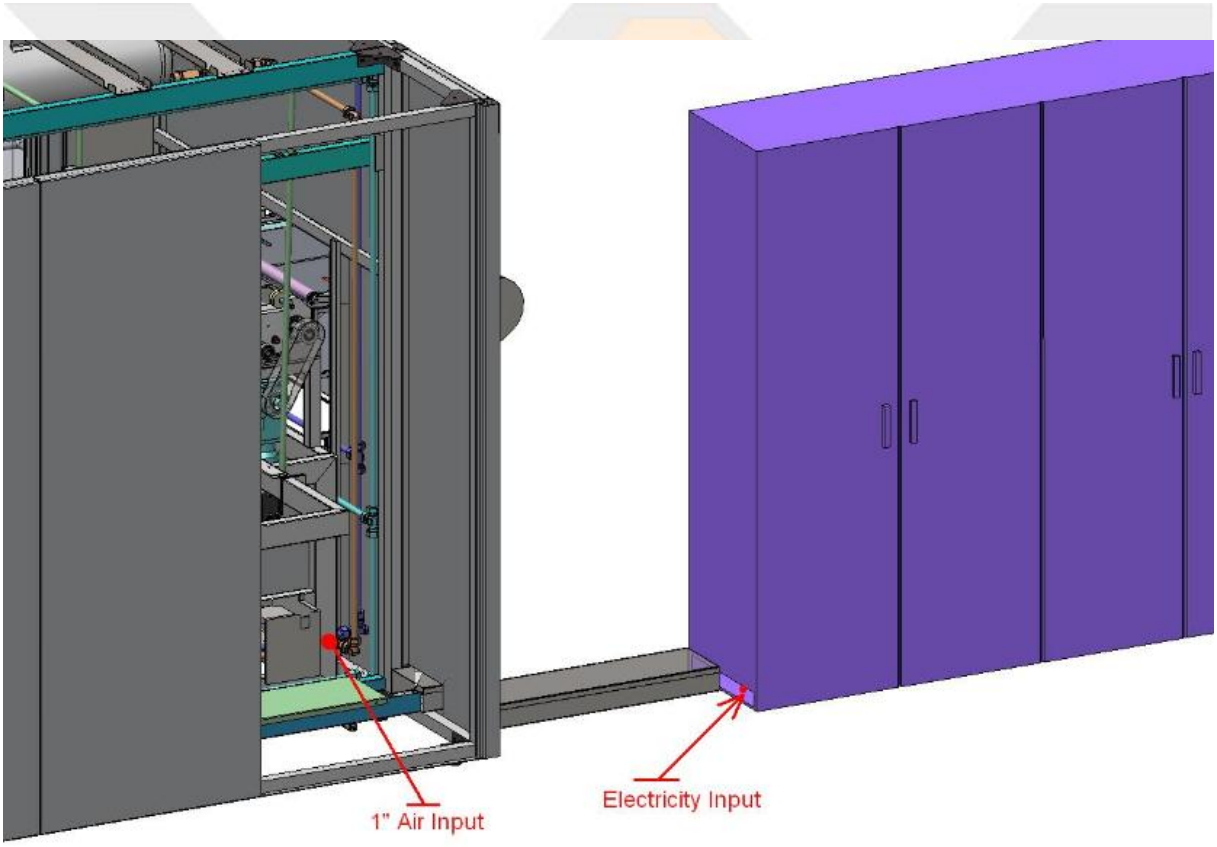
* Check all the emergency buttons. All the buttons are red and marked with yellow rings.
* Check all the door and moving system switches. The machine is supposed to stop operating when any guard is open.
* Check the emergency lights and alarm. They are supposed to operate in case of an alarm.
* Check the heat detectors before turning them on (room temperature) by using the control panel. Later, check if the heating level increases when the machine is on.
* Finally, check all the systems if they operate in manual mode.

5.1.2 THE FEEDING CONNECTIONS

The power supply connections must be done according to the law and regulations of the country where the machine will operate.

The pneumatic connections can be done via the use of 1” hose for the parts demonstrated in the pictures. Depending on the demand of the customers, a turn on-off valve can be put to the machine.

On the thermoforming machine, there is water input and output connections at location demonstrated on the next picture. The input and output of the water must be set correctly.



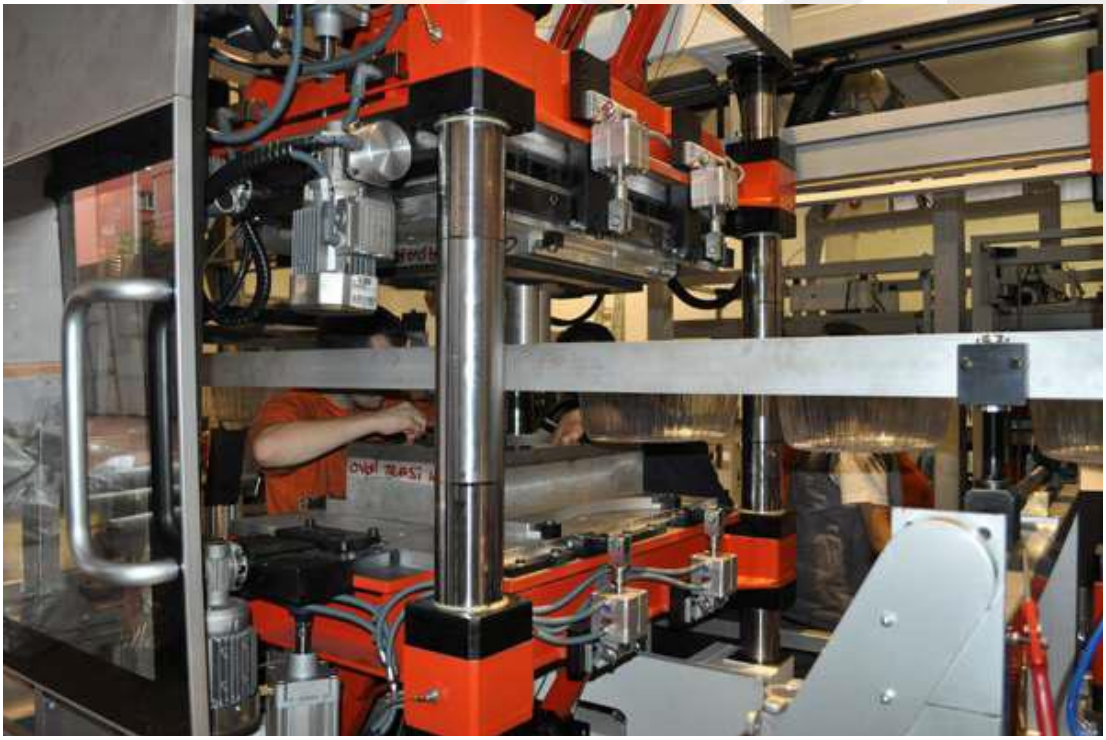
5.1.3 THE MOULD CONNECTIONS

The dimensions and connections of the machine must be compatible with the size and connection standards. Control the technical features of the machine. The entire moulds that are done by others manufacturers according to the demands of the customer must also compatible with these features.

The mould connections must be completed by the staff expert on the issue and with sufficiency to follow the technical procedures.

5.1.4 THE CUTTING EQUIPMENT CONNECTIONS

To connect the cutting equipment, the control buttons and cutting blocks must be turned on manually, right before the heating resistance is on. According to the first cuttings, the height of the cutting plaques must be tuned fine to cut the material.



5.1.5 THE MECHANICAL SETTINGS OF THE MACHINE

Some mechanical settings need to be done before the operation of the machine. These settings are done according to the materials and moulds used. Standard settings are here: The width setting of the chain sleds according to the width of the material to be used. During the adjustments, one should pay attention to the chain sled forming unit, the cutting unit or the stacking unit and not to hit the equipments.

CHAPTER 6

6. CONTROL PANEL & WORKING

6.1 SCREEN MENU

The touch screen is the main screen containing all the menus. To operate the machine, all the required settings and data can be accessed through the menus on this screen.

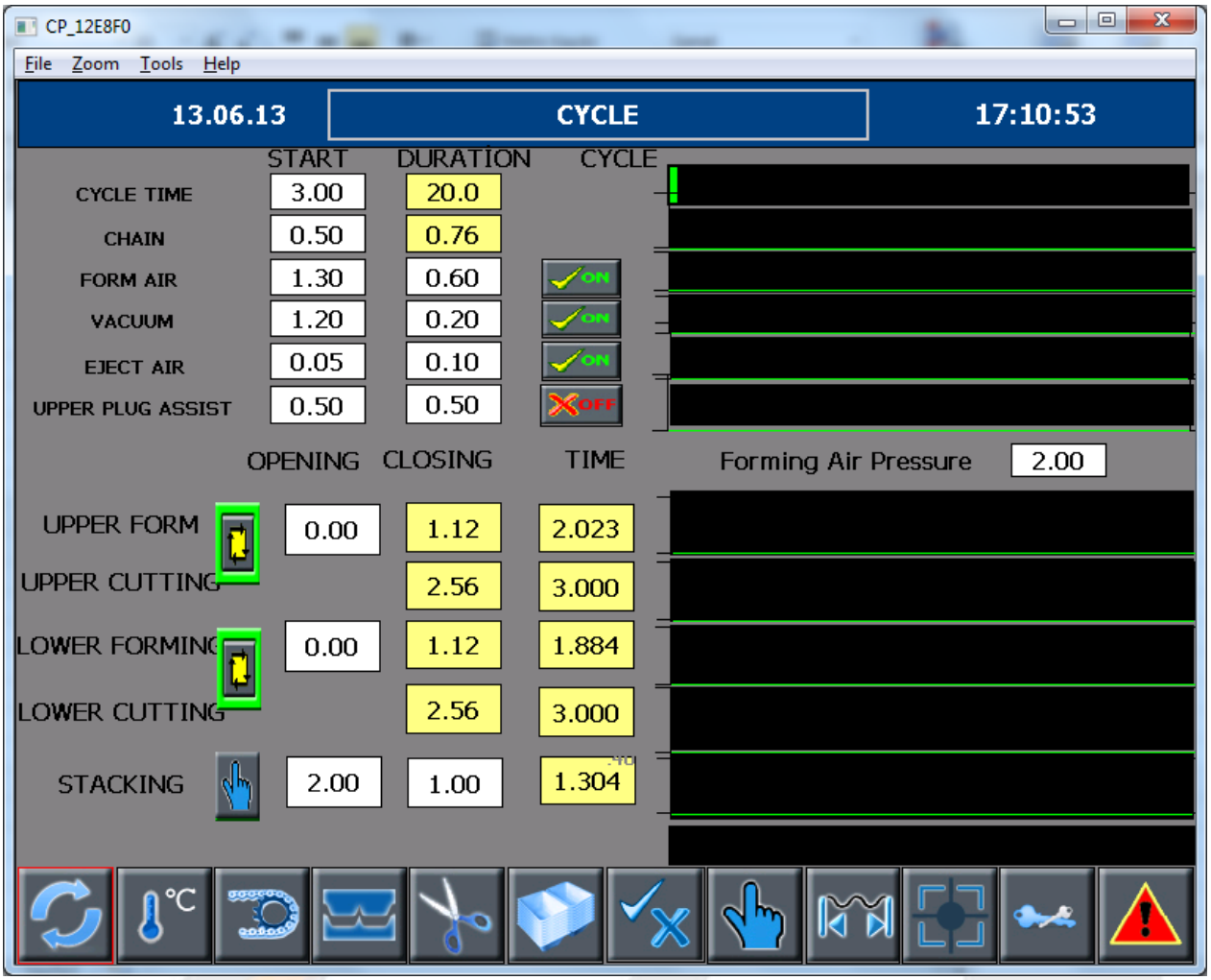
There are several settings screen on the main menu. These are;

Cycle, Heat Control, Lower Zone Temperature, Cutting and Other Adjustments, Chain Servo Settings, Forming Adjustment, Cutting Adjustment, Stacking Adjustments, Sweep Adjustments, Punching Adjustments, Manuel Control, Streching, Working Page, User Level Adjustments, Speed Graph, Digital Input and Output, Other Adjustment, Driver Ramp Adjustments, Selections, Alarms and Receipe.

Pages that have a button at up-right corner means that there is an another setting page next. And pages that have a button at up-left corner means that you can go previous page by pressing on it.

On touching the place with changeable data, a keyboard and a numerator come to the screen. Some input boxes demonstrate the data that can change and some other input boxes demonstrate the data that can be changed only by the staff of the authorized service.

6.1.1 CYCLE



On this page, working periods of some parts of the machine can be set. Also the cycle time can be seen here.

P/S: Values can be given on parts with white background

Cycle Time

The first box from the two boxes near cycle time is for cycling time. The second box is for the completed cycle time. The cycle time is the time spent for forming, cutting and stacking. In the first box, this value can be submitted as “second”.

Chain

Start and duration values on the line of “chain” provide information deciding on when the chain system starts and finishes during the cycle time.

Form Air

Here the forming air starting and duration times can be changed. The ON/OFF indicator on the rightmost of the line demonstrate whether the air valve is on or off at that time.

Vacuum

These values control the vacuum air system starting and duration times. The ON/OFF indicator on the rightmost of the line demonstrate whether the air vacuum is on or off at that time.

Eject Air

These values control the eject air system starting and duration times. The ON/OFF indicator on the rightmost of the line demonstrate whether the eject air is on or off at that time.

Upper Plug Assist

These values control the upper plug asist system starting and duration times in the cycle. The ON/OFF indicator on the rightmost of the line demonstrate whether the upper plug assist is on or off at that time.

Upper Forming

These values determine when the upper forming unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine. It goes downward at closing time and goes upward at opening time.

Upper Cutting

These values determine when the upper cutting unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine. It goes downward at closing time and goes upward at opening time.

Lower Forming

These values determine when the lower forming unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current

time of related movement part of the machine. It goes upward at closing time and goes downward at opening time.

Lower Cutting

These values determine when the lower cutting unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine. It goes upward at closing time and goes downward at opening time.

Stacking

These values determine when the stacker unit starts movement in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine.

Lower Punching

These values determine when the lower punching unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine. It goes upward at closing time and goes downward at opening time.

Upper Punching

These values determine when the upper punching unit starts to closing and opening in the cycle movement of the machine. Time column demonstrates the current time of related movement part of the machine. It goes downward at closing time and goes upward at opening time.

Form Air Pressure

Here forming air pressure value can be set as bar unit.

Pressing this button makes the cycle time is changed option automatic opening and closing times

6.1.2 HEAT CONTROL

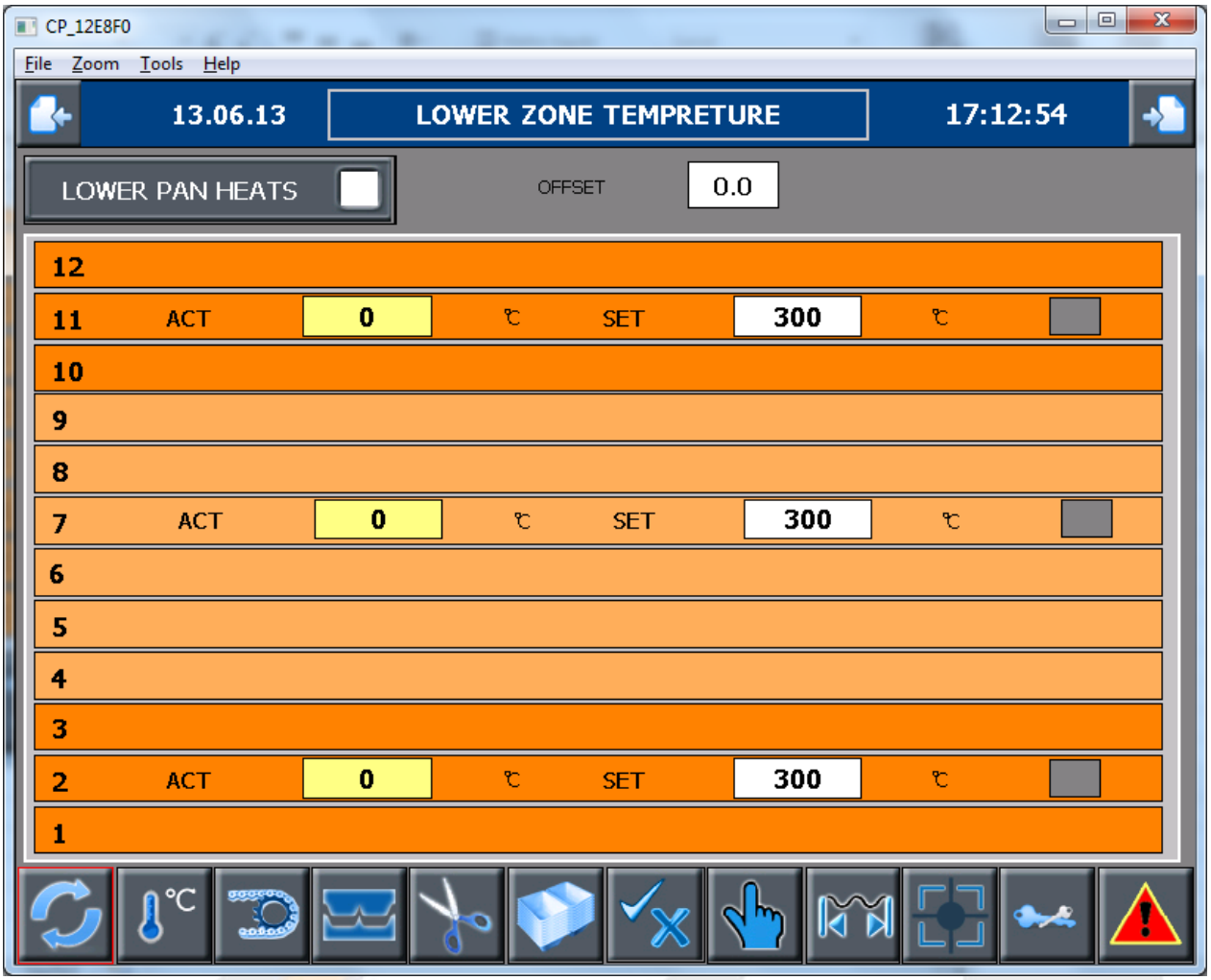
CP_12E8F0
File Zoom Tools Help
13.06.13
HEAT CONTROL
17:12:31
UPPER PAN HEATS
OFFSET
0.0
Max Temperature
614.9
0.0
12 ACT 0 ℃ SET 480 ℃
11 ACT 0 ℃ SET 460 ℃
10 ACT 0 ℃ SET 450 ℃
9 ACT 0 ℃ SET 410 ℃
8 ACT 0 ℃ SET 410 ℃
7 ACT 0 ℃ SET 400 ℃
6 ACT 0 ℃ SET 400 ℃
5 ACT 0 ℃ SET 410 ℃
4 ACT 0 ℃ SET 410 ℃
3 ACT 0 ℃ SET 470 ℃
2 ON ACT 0 ℃ SET 480 ℃
1 ON ACT 0 ℃ SET 485 ℃
14 13 12 11 10 9 8 7 6 5 4 3 2 1
ACT 0 ℃ SET 400 ℃

This panel demonstrates all the heating values of the areas with a temperature. All the heating columns and rows can be configured one by one.

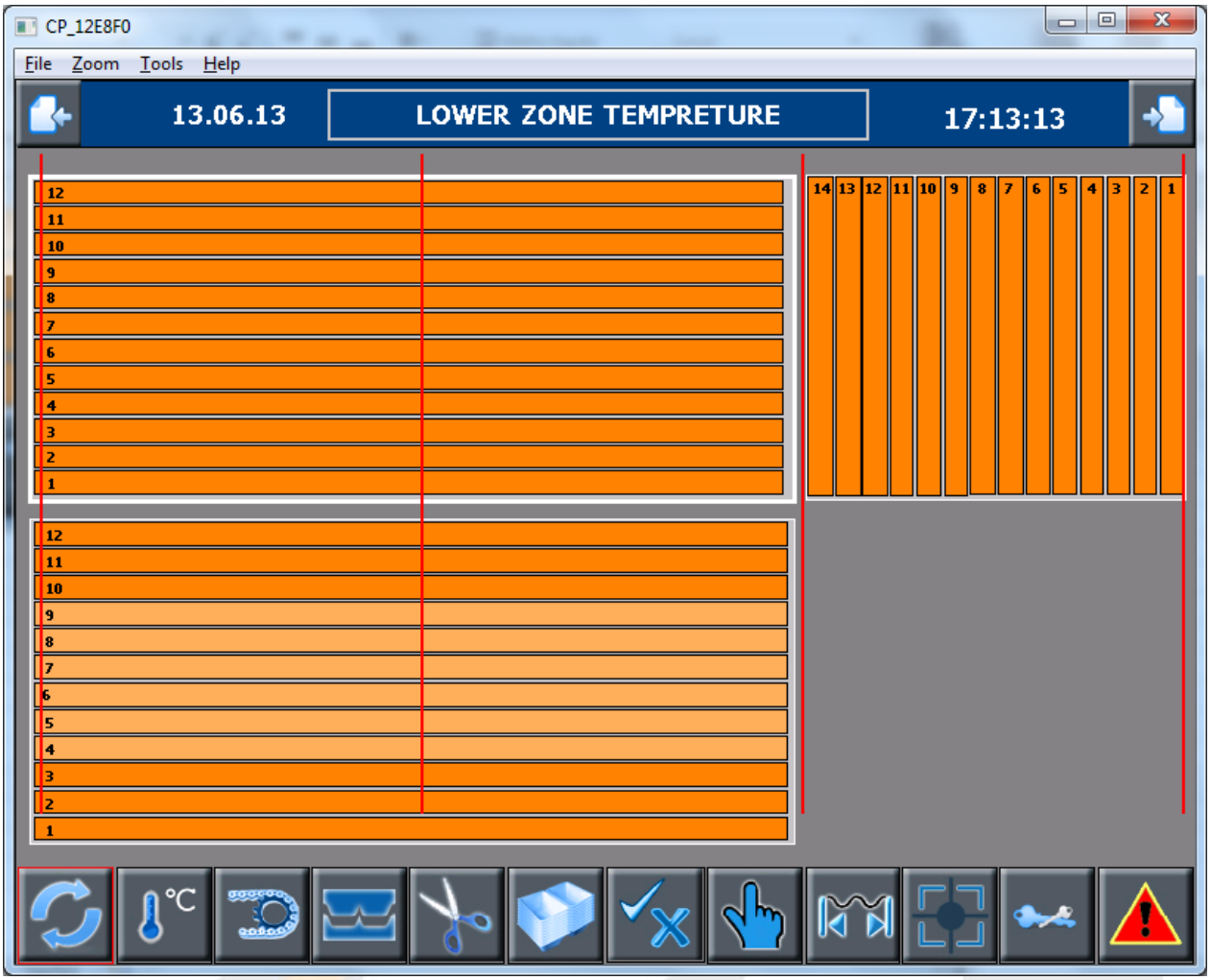
All zones temperatures can be set by SET values one by one. The actual degrees of zones can be seen from ACT value boxes. All temperatures can be offset from OFFSET value box and all temperatures can be tolerated.

Upper heater has14 vertical and 12 horizontal zone. ON/OFF buttons on stage 1 and stage 2 area are used to activate and deactivate 1.12. and 2.11. zone heater when using narrow moulds.

The maximum temperature of the oven depending on the processed product can be entered in the Max Temperature section by the technician.

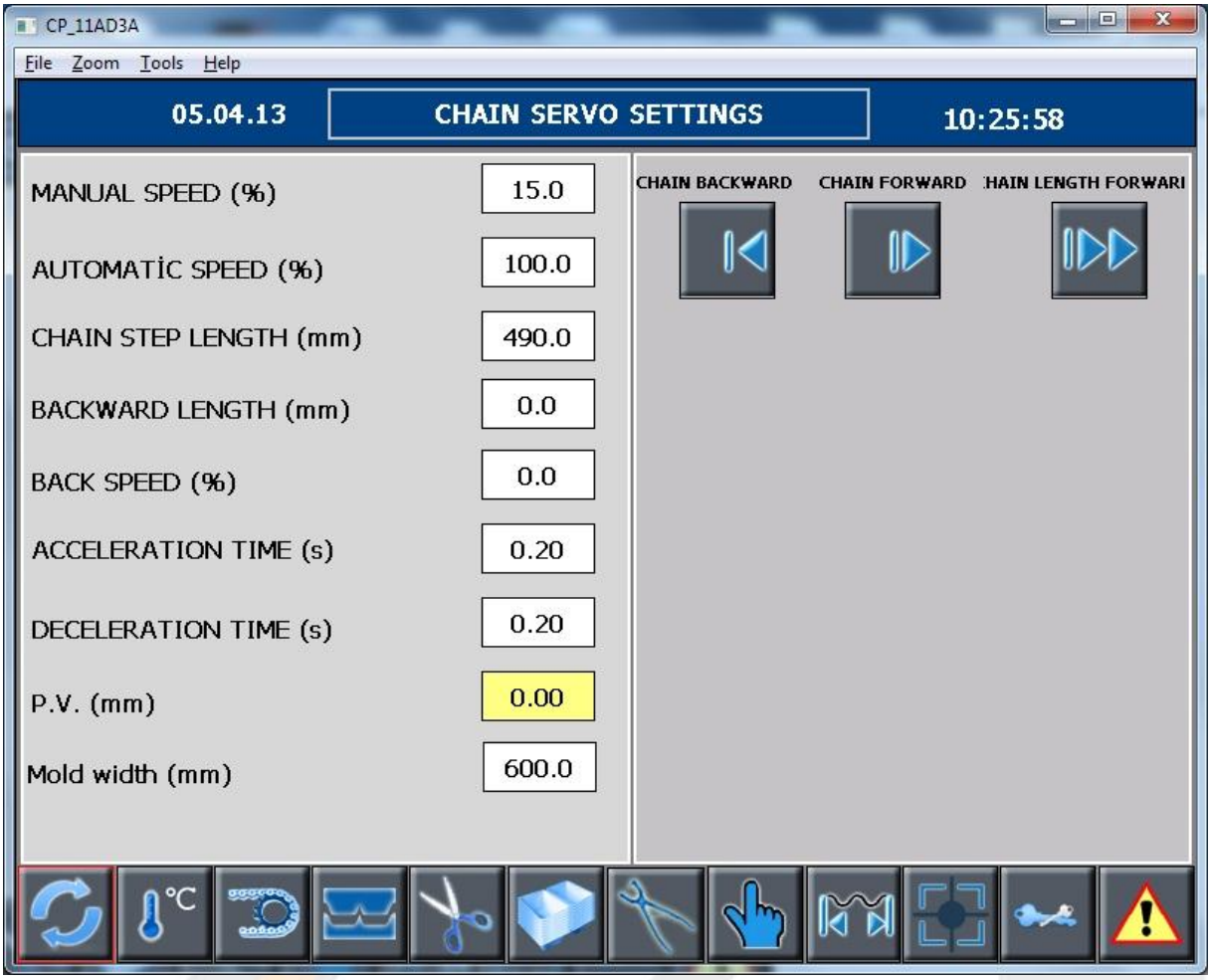


Lower zone heater has 3 horizontal sections which 1.2.3. are first, 4.5.6.7.8.9 are second and 10.11.12. are third heater zone. Lower heater totally has 3 heater zone.



values appear in this section of the upper and lower heating elements. red line shows the pitch of the mold

6.1.3 CHAIN SERVO SETTINGS



When the chain backward button is pushed, the chain system goes back manually. Likewise, the chain system goes forth if the chain forward button is pushed.

With chain length forward button, the chain system moves one step forth.

The value on Manual Speed (mm/s) is the velocity value of the chain system when it moves manually.

The value on Automatic Speed (mm/s) is the velocity value of the chain system when it moves automatically.

The value on Chain Step Length (mm) is the value of the chain system how much it moves when it moves.

The value on Backward Length (mm) is the value of the chain moving length when it moves one step back ward. This section serves to reduce the failures caused by gaps in the chain system in the course of years of usage. Yeniyurt service is needed.

The value onChain Backward Speed (mm/s), in this section Backward Length, engine speed is to be entered.

Acceleration Time (s) determines the acceleration value of the chain when it moves.

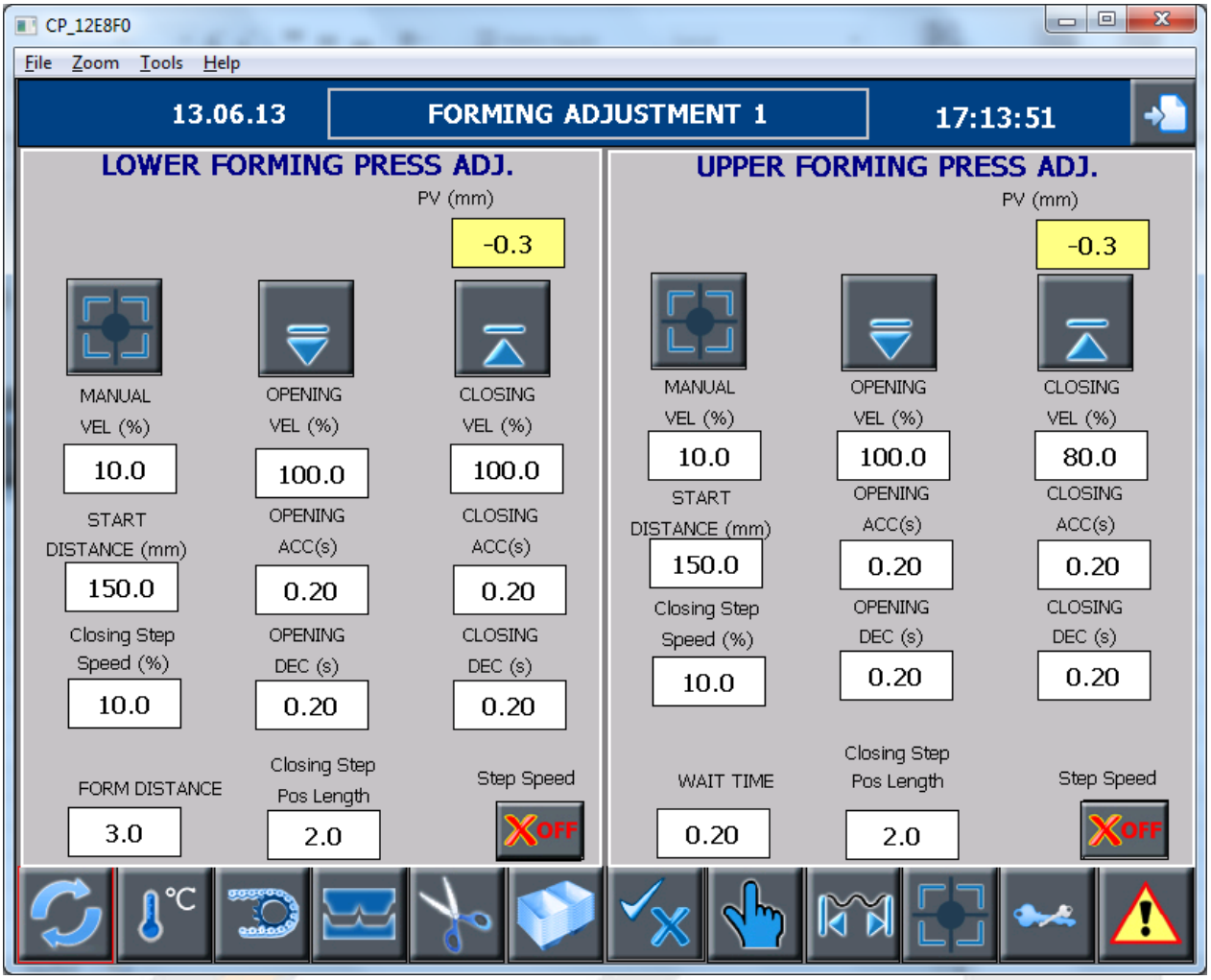
Deceleration Time (s) determines the deceleration value of the chain sytsem when it is slowing and stopping.

P.V. (mm) value shows the actual position of the chain system.

Mould Width(mm) In this section the mould width is to be entered.

P/S: The technician has Access to this page.

6.1.4 FORMING ADJUSTMENT 1



When dotted square button pushed, lower/upper forming system moves to its origin position.

MIN and MAX input boxes are determine the minimum and maximum levels of lower/upper forming press.

“PV (mm)” parts demonstrate the existing value of upper and lower forming press.

By “Manual” up and down arrow buttons, related unit movements can be operated with up and down buttons manually.

“Manuel Vel (%)” values determine the speed of lower/upper forming press while moving by manual buttons.

“Opening Vel (%)” values determine the opening speed of lower/upper forming press and “Closing Vel (%) determines the closing speed of lower/upper forming press.

The value that entered to “Start Distance (mm)” input box determines the starting distance position of lower/upper forming press.

“Opening Acc (s)” values determine the acceleration of the lower/upper forming press by unit of seconds and “Closing Acc (s)” values determine the acceleration of the lower/upper forming press by unit of seconds.

“Opening Dec (s)” values determine the deceleration of the lower/upper forming press by unit of seconds and “Closing Dec (s)” values determine the deceleration of the lower/upper forming press by unit of seconds.

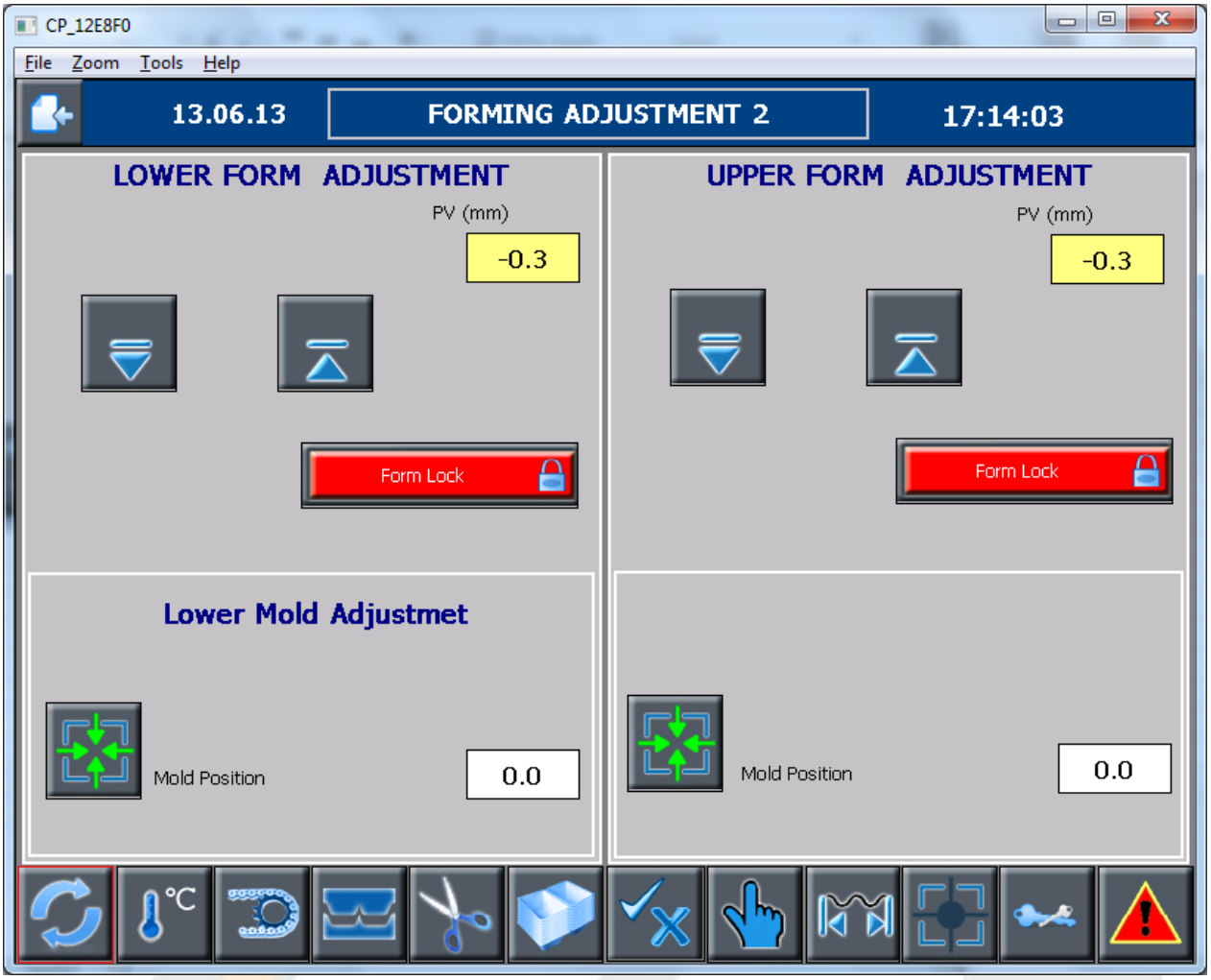
“Closing Step Speed (%)” value determine the steps as percentage while lower/upper forming press systems are closing.

“Closing Step Pos Length” value determine the steps as length while lower/upper forming press systems are closing.

“Step Speed” on/off button selects the step speed action is on or off.

Form Distance When the value to be written in this section post in this section begins forming the air before the cut-off value will make the form and the form must be set to miss the weather, for example (0) be written

6.1.5 FORMING ADJUSTMENT 2



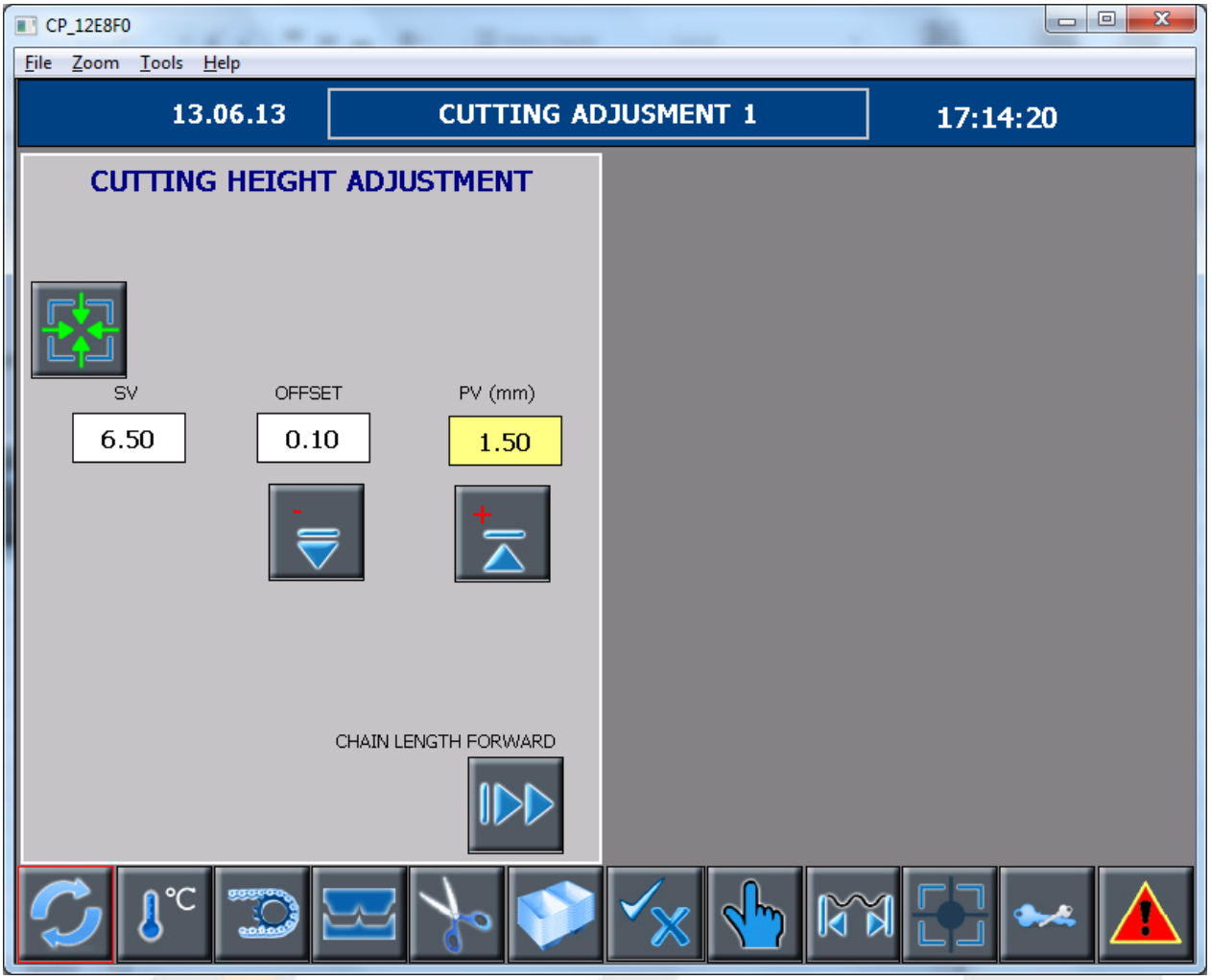
Pv pozizyonunu shows snapshots of the mold

pozizyonu mold removal is determined with the help of the up and down buttons, the value is written to the following section of the liquid to the next by pressing the button changes the upper and lower molds mold removal position is automatically

“Form Lock”,.There are buttons at the bottom of the page for lower and upper forming moulds that activates and de-activates the related unit such as

Mold Position Pressing this button on the right side is sent to the setpoint

6.1.6 CUTTING ADJUSTMENT 1



When pushed the green arrowed button while pressing auxiliary button from control panel, cutting height servo motor goes to its origin position.

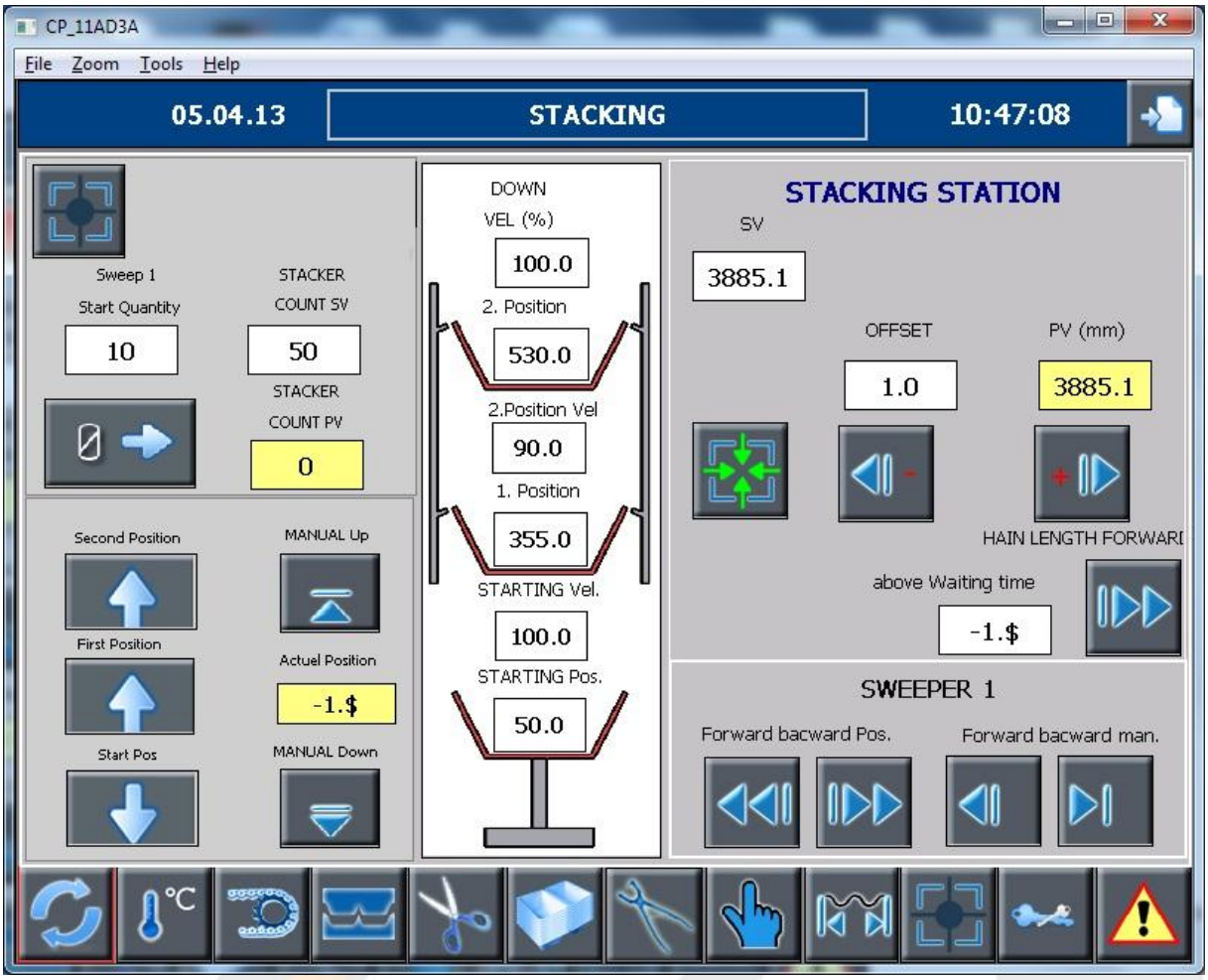
“SV (mm)” areas can be set by operator to determine cutting height and cutting station position manually.

“PV (mm)” parts demonstrate the existing value of cutting height and cutting station position.

By “Manual” up/down and forward/backward arrow buttons, related unit movements can be operated with up and down buttons manually.

“Chain Length Forward” button used to forward chain system one step forward.

6.1.7 STACKING ADJUSTMENT 1



Square button positions the lower plucking system to origin.

Left half of page is for sweeping settings. “Start Quantity” determines that when sweep system first works after first products stacked.

“Stacker Count SV” input value box determines the count of total product that stakced before sweeping system is active. And “Stacker Count PV” shows the actual stacked material on stacking roof.

Reset button labeled with “0->”, resets the stacking system count number.

“Second Position” button moves the stacking system to second level position manually and “First Position” button moves the system to first level. Also “Start Position” button moves the stacking sytem to it’s initial position.

“Manual Up” and “Manual Down” buttons move the stacking sytsem to up and down manually. “Actual Position” value box indicates the actual system position.

The half right page area labeled “Stacking Station” includes settings about stacking station.

“SV” box value the stacking station position to move determines the system.

“PV (mm)” box shows the actual position of the stacking station.

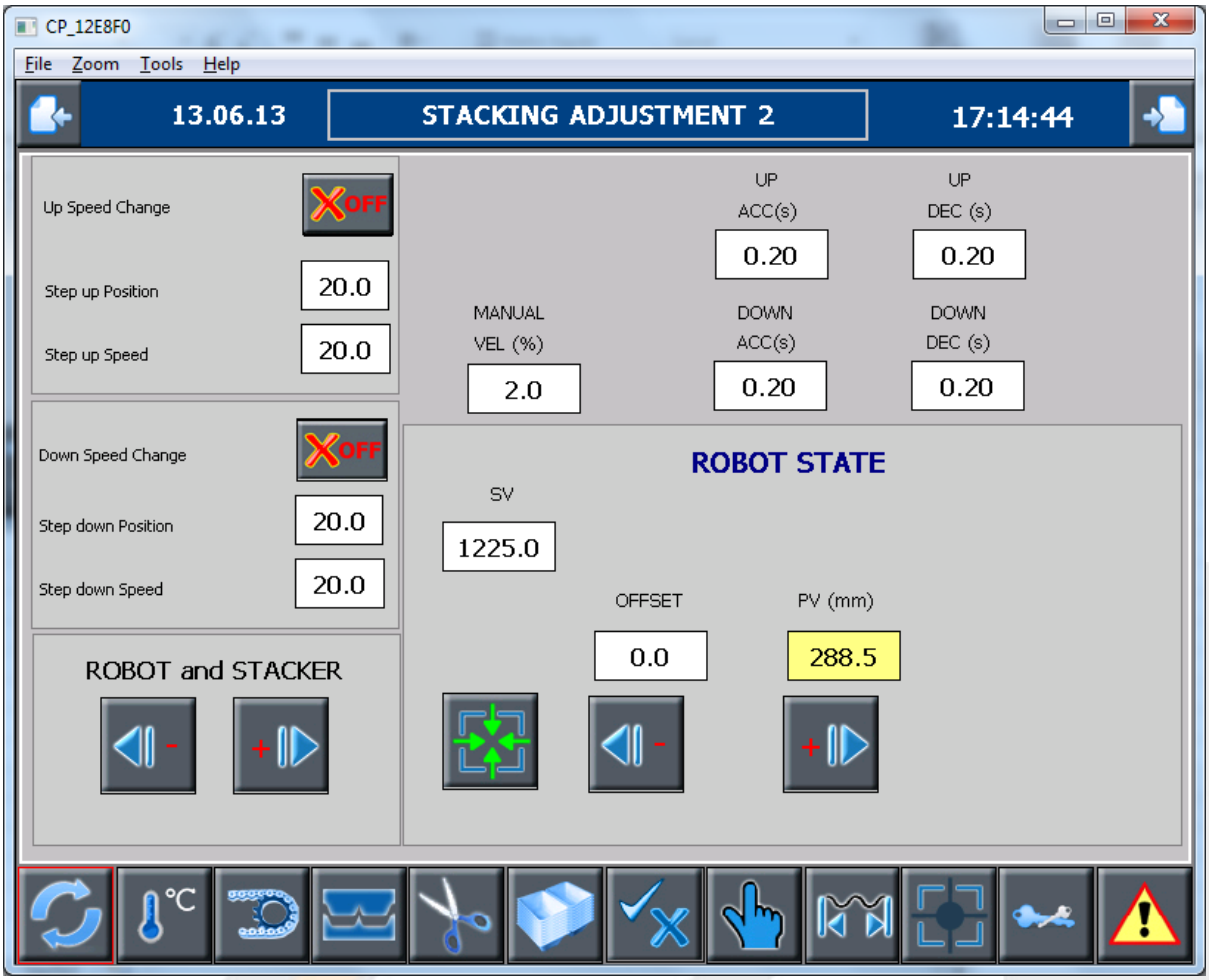
“Left” and “Right” arrow buttons move the station to backward and forward. The buton with labeled twin arrow moves the chain to one step forward

“Open Waiting time (s)” keeps the upper and lower forming blocks waiting as long as the time entered in this section.

“Chain Length Forward”pressing button used to forward chain system one step forward by pressing auxiliary button

The buttons at “SWEEPER 1” area are used to move the sweeper 1 to forward and backward one step and the second set of forward backward buttons are used to move the sytem manually while pressed.

6.1.8 STACKING ADJUSTMENT 2



"Up Speed Change" and "Down Speed Change" ON/OFF buttons activate and deactivate the speed change of up/down stacking system.

"Step up position" determines the position of stacking system when step system is at up.

"Step up speed" determines the speed of the stacking system's step property.

"Manual Vel (%)" value determines the speed of stacking system when it's controlled manually.

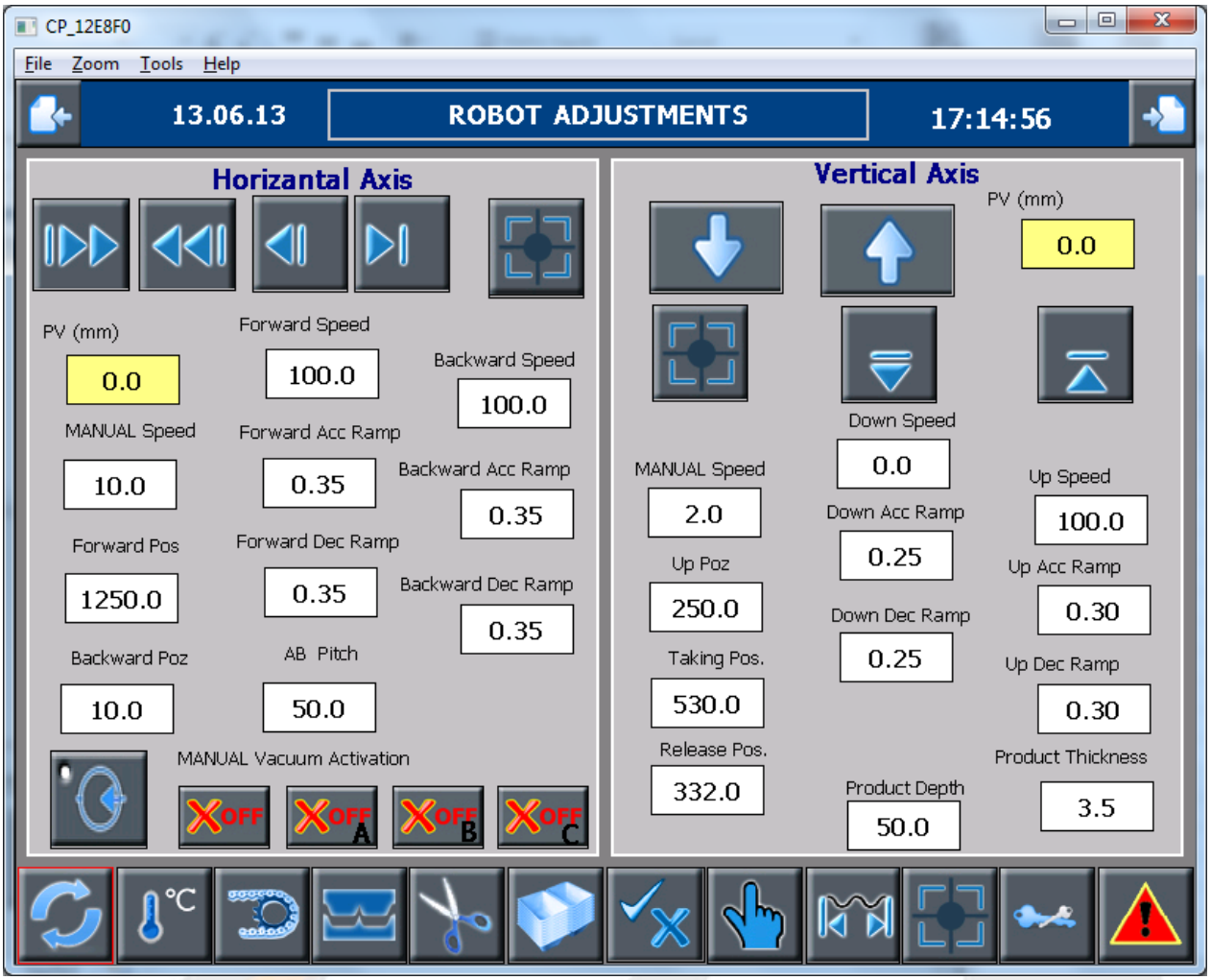
"UP ACC(s)" and "DOWN ACC(s)" values determine the acceleration of stacking system when its going to upward/downward.

"UP DEC(s)" and "DOWN DEC(s)" values determine the deceleration of Stacking system when its going to upward/downward

Robot and Stacker allows the robot to move that unit and sorting unit at the same time

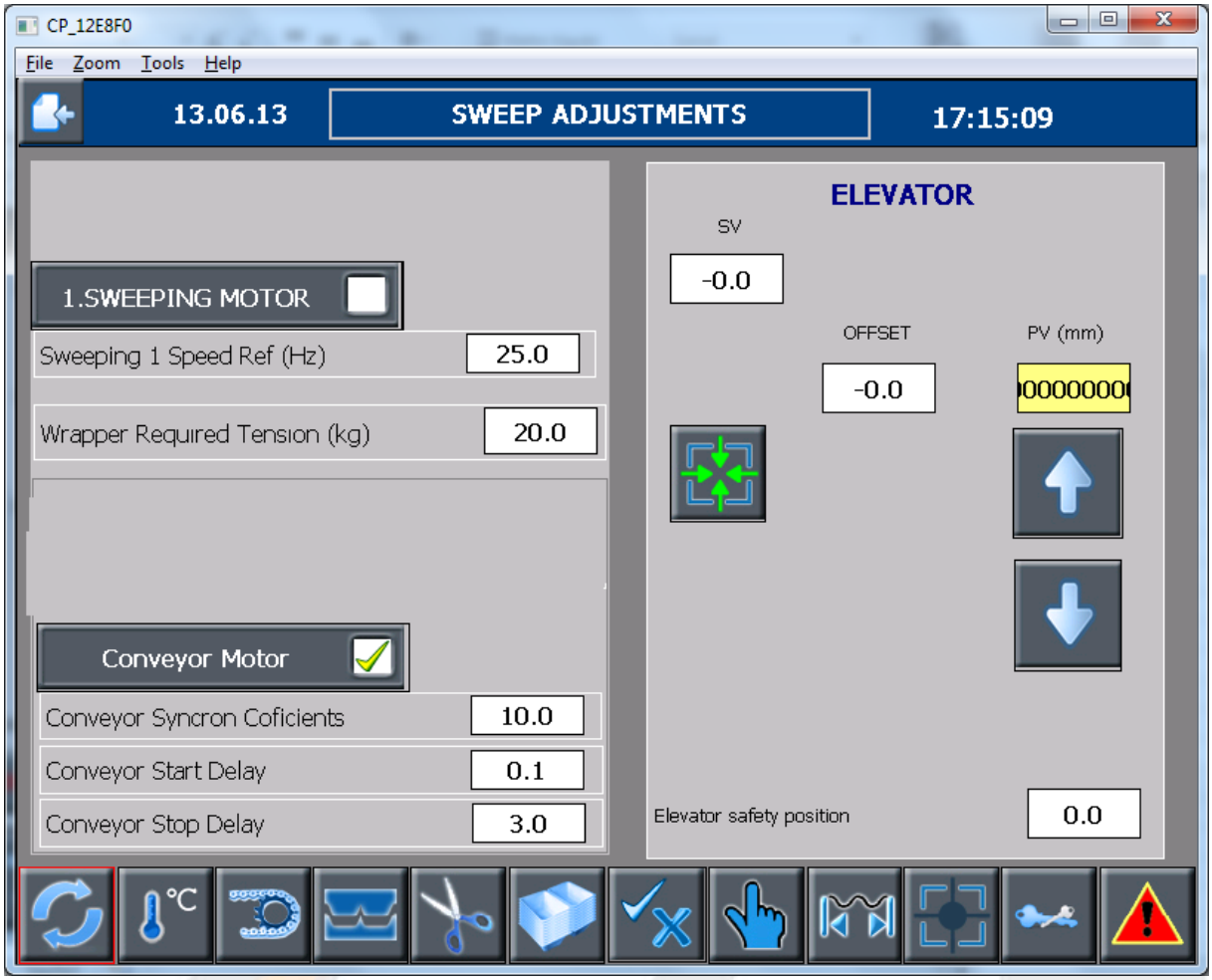
Robot State type setting unit ensures that the center of the robot unit

6.1.9 ROBOT ADJUSTMENTS



horizontal and vertical distances and velocities of the robot is set to move the robot vacuum system valves are provided on the selection of valves and ABC

6.1.10 SWEEP ADJUSTMENTS

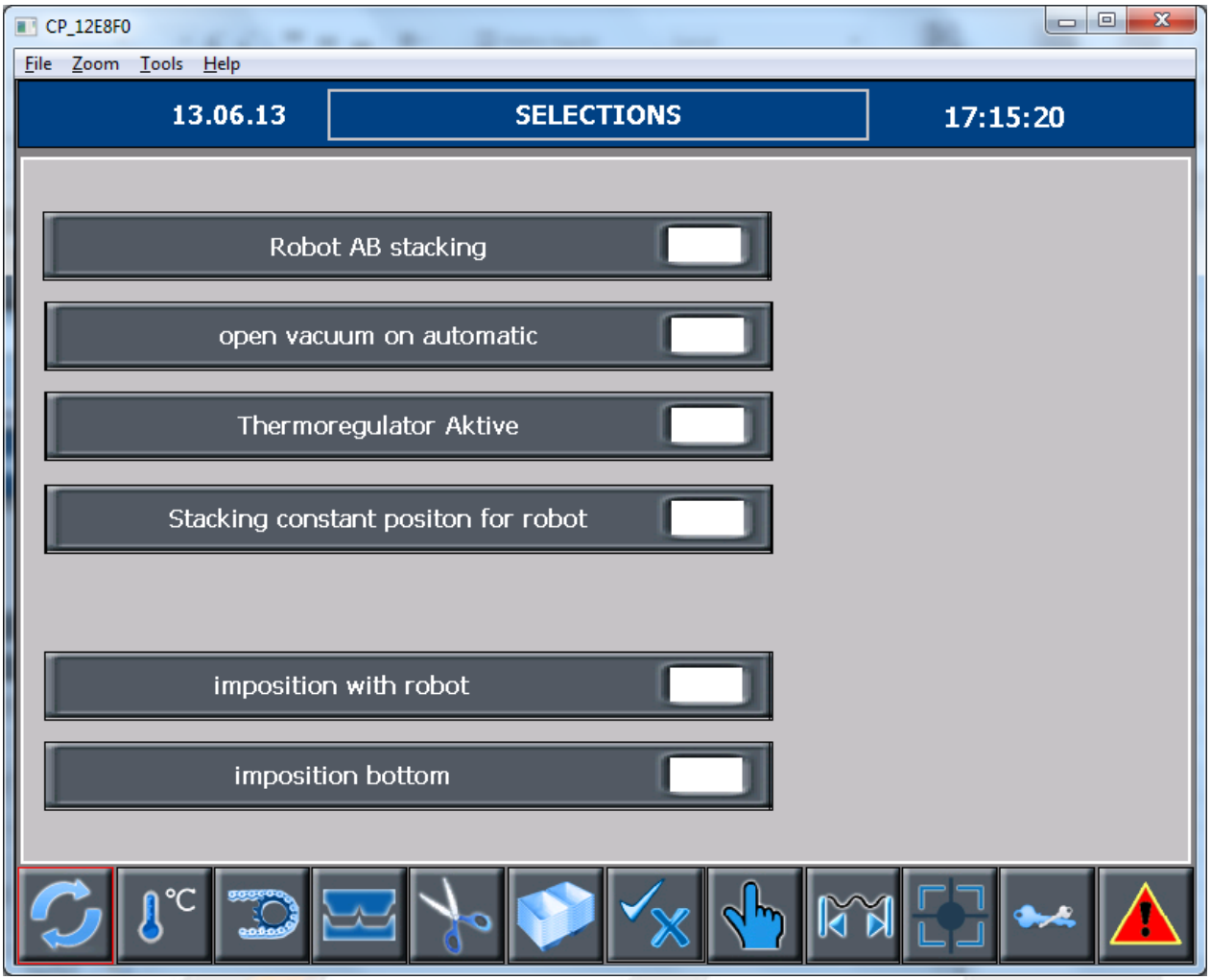


Sweeping adjustments for stacked products on the stacking roof can be set on this page.

"Sweeping speed referance (Hz)" and "Wrapper Required Tension (kg)" values can be set by related input boxes.

"Wrapper Required Tension (kg)" value adjusts the tension required for the wrapper system.

6.1.11 SELECTIONS



RobotAB Stacking AB When it Works

Open Vacuum on Automatic When it Works

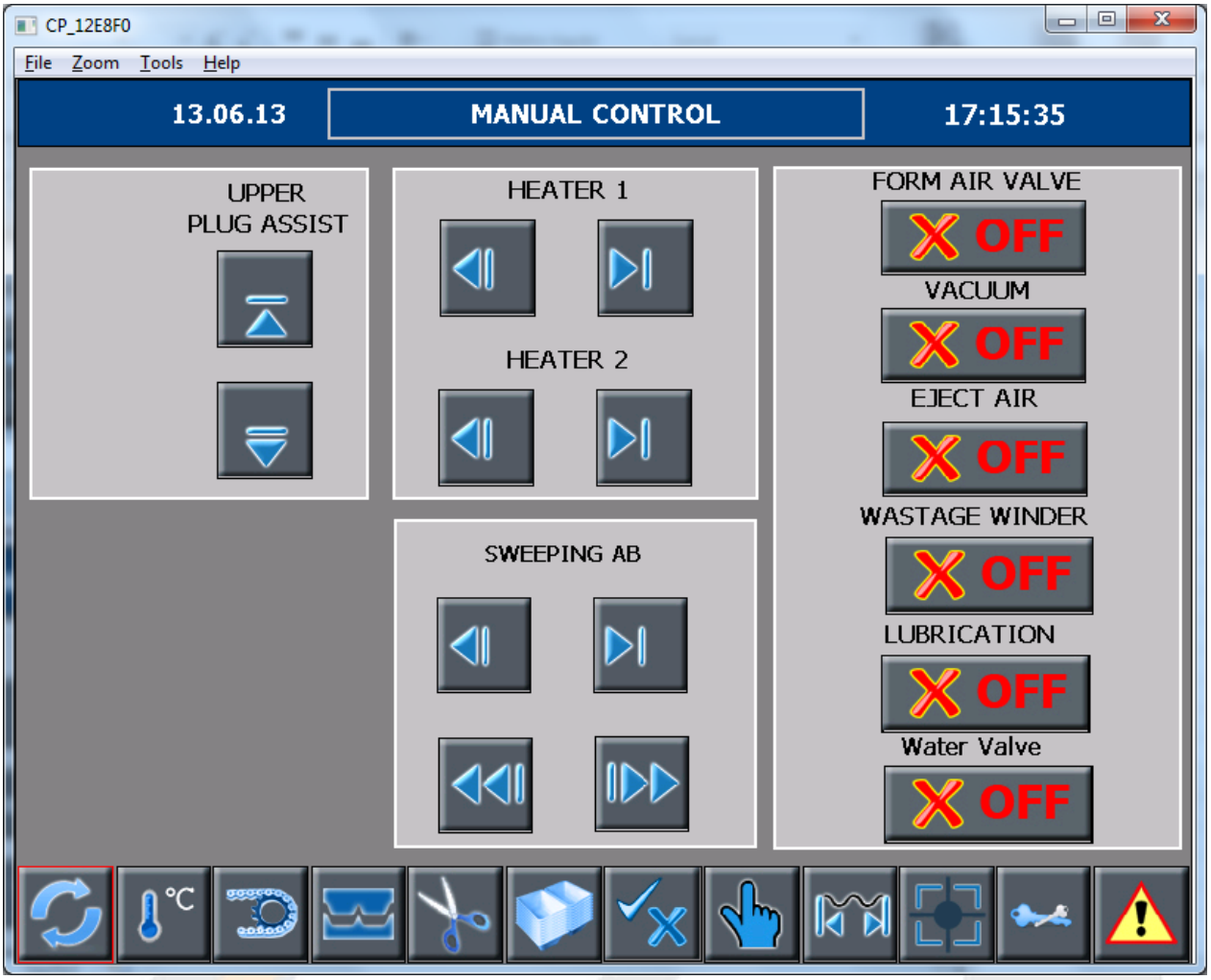
Thermoregulator Aktive When it Works

Stacking Constant Positon for robot rises up to the bottom step is selected in the same way marshaling step robot is high

İmposition With robot When it Works

İmposition bottom When it Works

6.1.12 MANUAL CONTROL



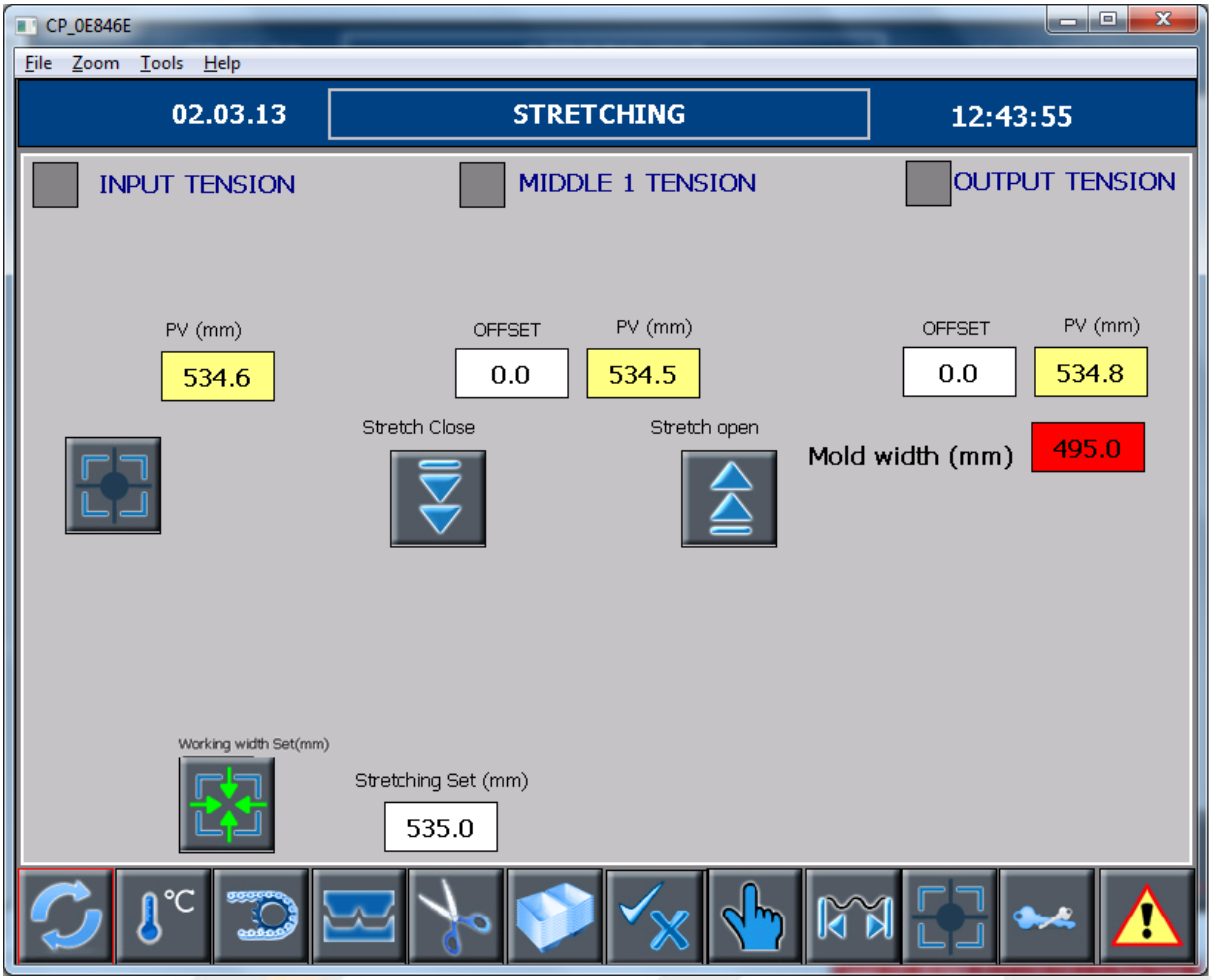
All buttons on this “Manual Control” page are used to move the labeled system by manually and selection to on or off.

Upper plug assist up and down button are move the plug asist to up and down by manually.

Heater1-2 backward and forward arrow buttons are moves the heater system to inside and outside of machine.

“Form Air Valf”, “Vacuum”, “Eject Air”, “WastageWinder”, “Lubrication” and “Water Valve” on/off buttons are activate and deactivate the related systems.

6.1.13 STRECHING



There are “Input Tension”, “Middle 1 Tension”, and “Output Tension” sector stretch settings for chain can be adjusted on this page.

“Offset” value input box for all these sectors to offset actual values.

“PV (mm)” boxes demonstrate the actual position of all stretch sectors.

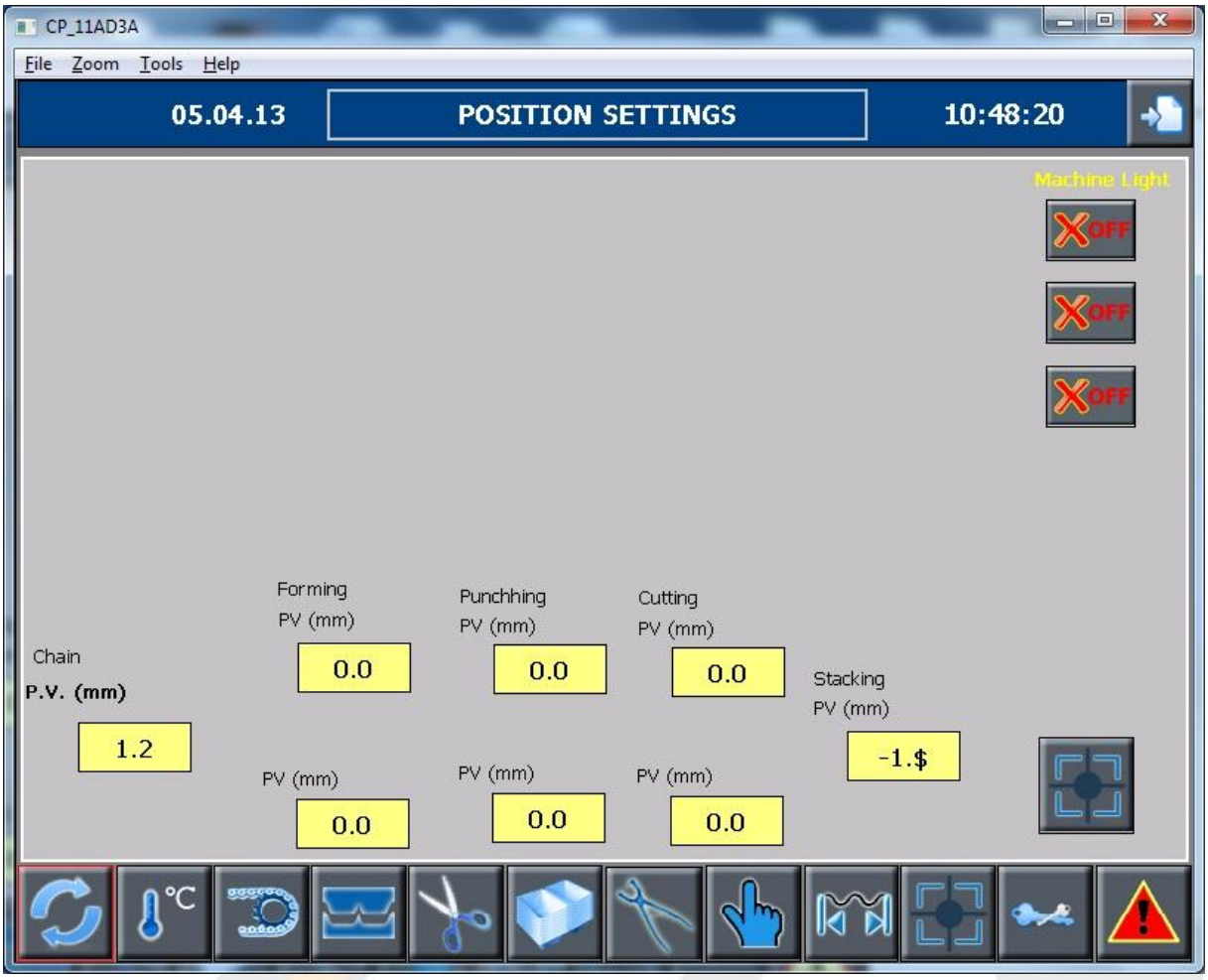
When dotted square button pushed, all stretch sectors move to their origin position.

When dotted square button pushed, stretching system moves to its origin position.

“ ” is Set value button. It sets to the value entered in SV section.

Mould Width(mm) Mould width is to be entered in this section.

6.1.14 WORKING PAGE



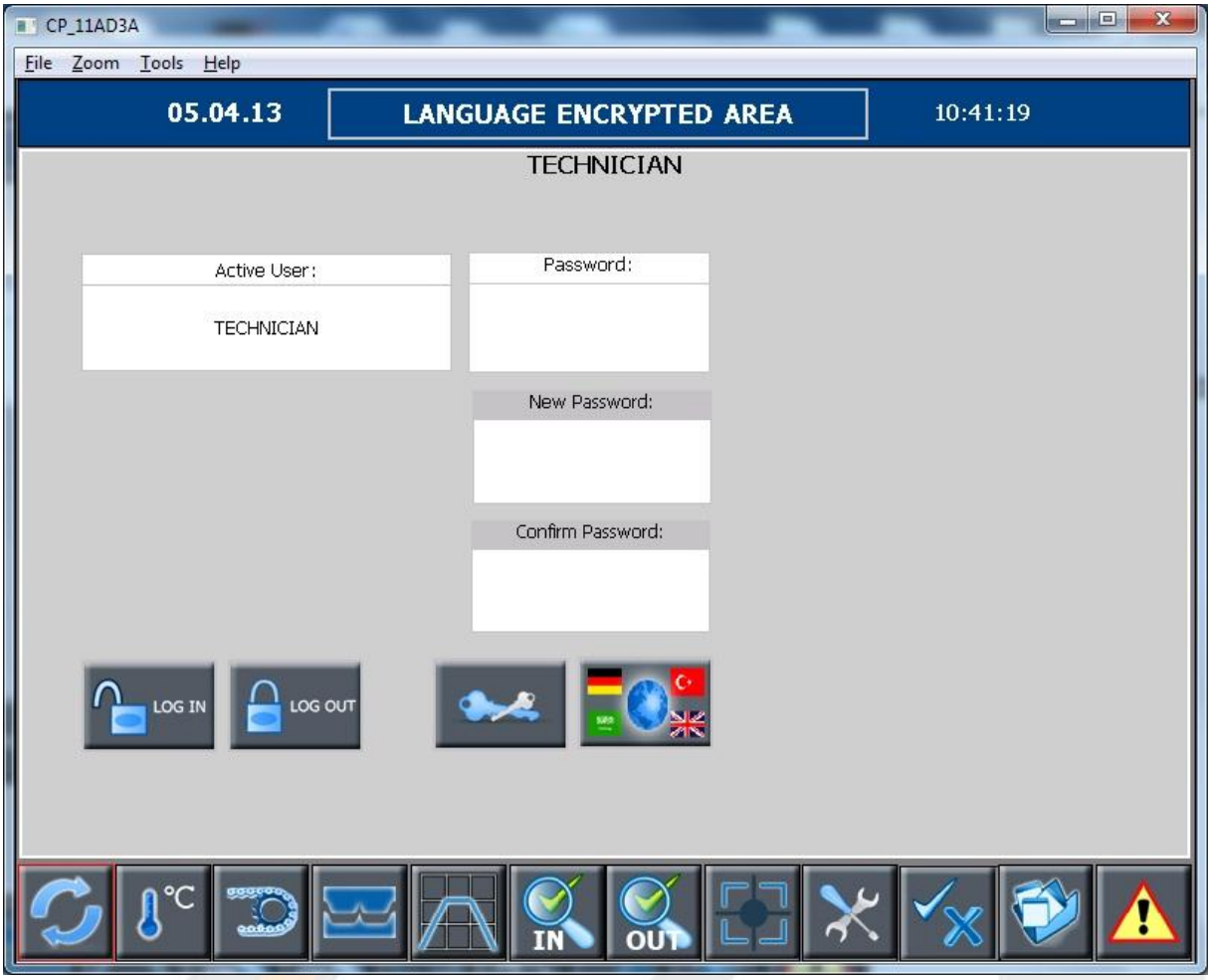
Home set positions can be set on this page and actual positions of stations demonstrated by “PV (mm)” value boxes.

When dotted square button pushed, all stations and system move to their origin position.

Upper/lower forming, cutting and punching station home positions can be set one by one.

Machine lighting makes the ligthing inside the machine active or passive.

6.1.15 USER LEVEL ADJUSTMENT

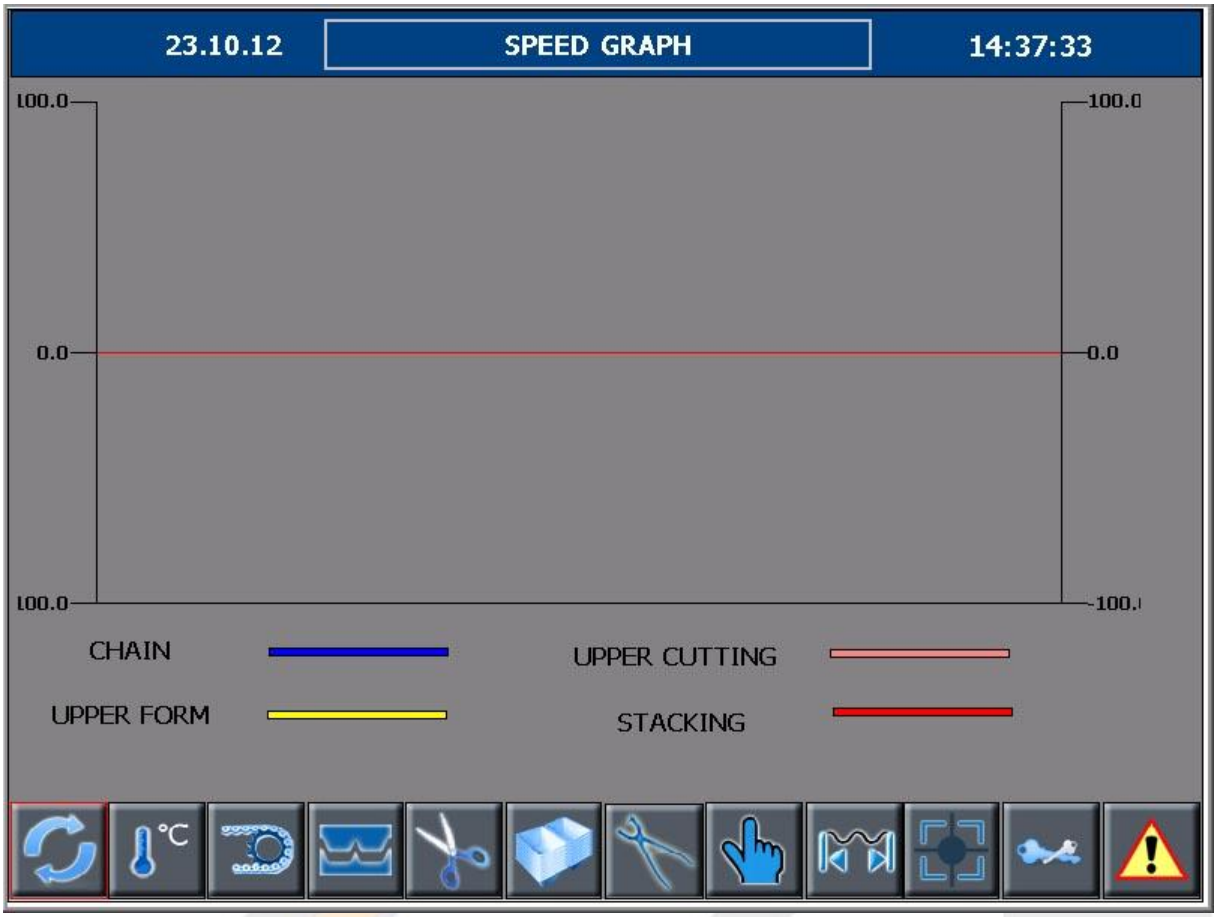


User level and control panel language settings are on this page. You can choose the language you prefer by pressing on it.

Also a password protection system is included to system for using by Yeniyurt Machine technicians. These password protected setting areas are need to be change only by Yeniyurt techinicians. Otherwise, these settings can be cause injuiry of personel or damage the machine systems.

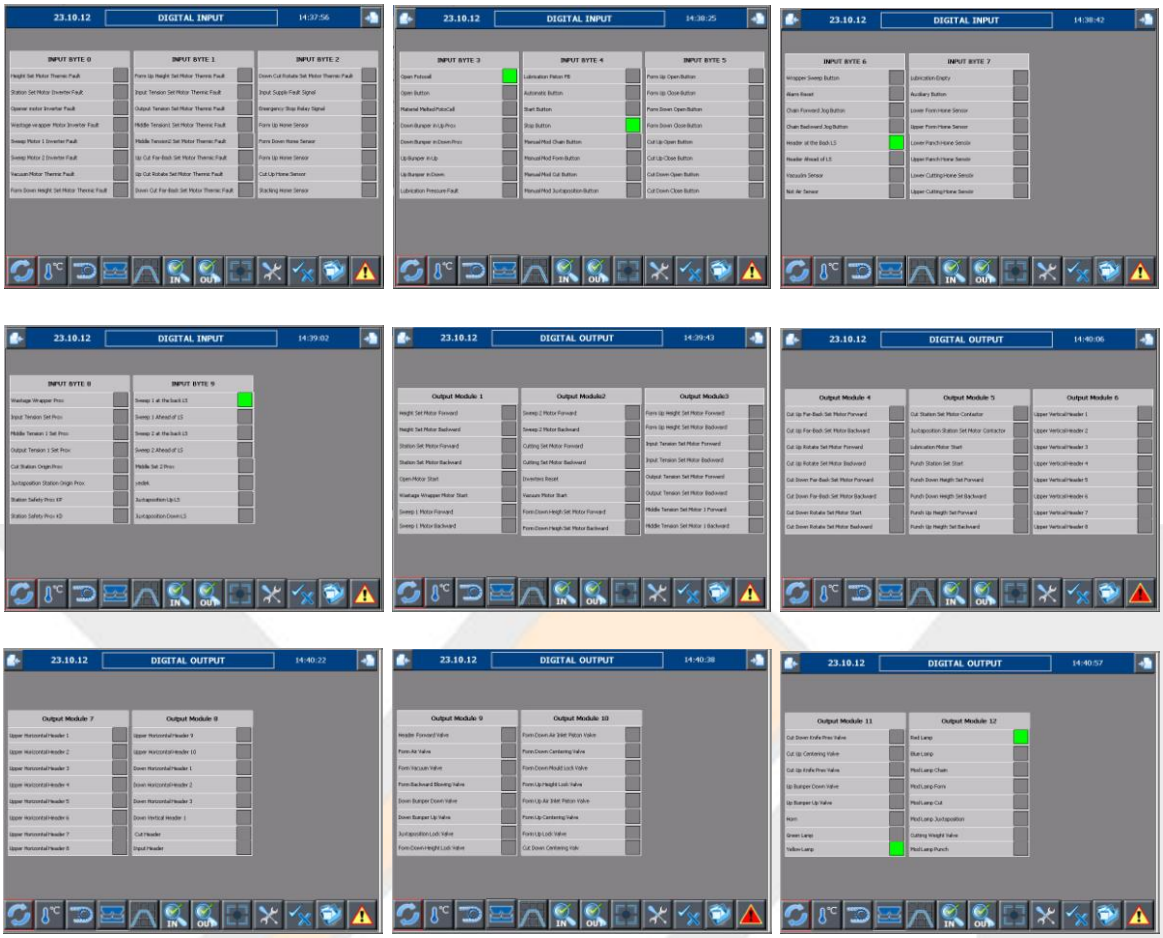
CP_11AD3A
File Zoom Tools Help
05.04.13
CONTACT
09:46:46
English
IN
OUT

6.1.16 SPEED GRAPH



Speed Graph page shows the graphical values of chain, upper cutting, upper form and stacking systems.

6.1.17 DIGITAL INPUT AND OUTPUT PAGES



Digital output pages are used to control all systems and sensors if they are working or not.

When green light indicates at the the end of rows, that means the system written on this row is working true at the moment.

You or Yeniyurt Machine techinicans can check the system parts by these pages.

6.1.18 OTHER ADJUSTMENT 1

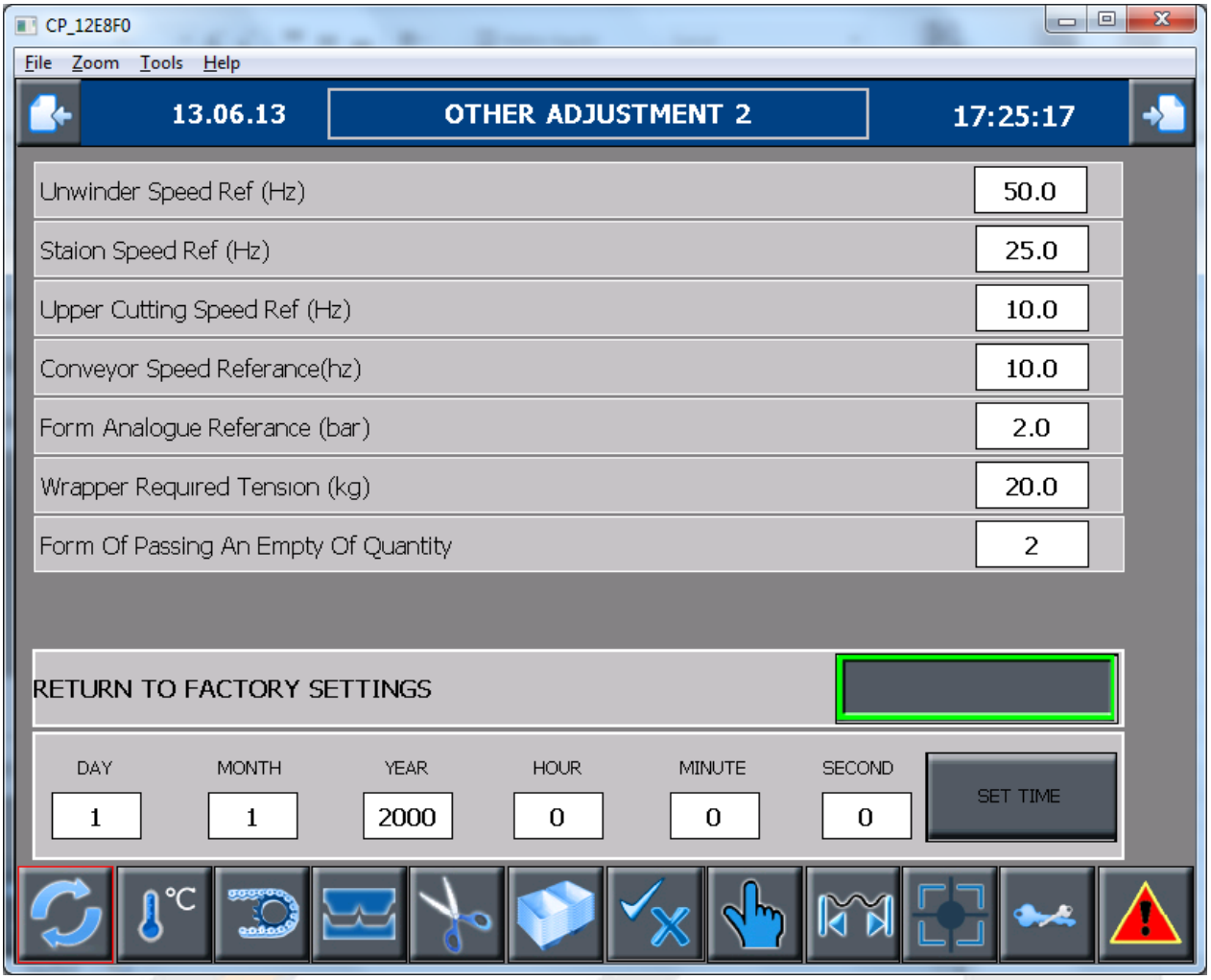
"Lubrication Start Press Quantity" value determines the start action time of lubrication system. When count completed in this value box, the lubrication system starts to pump oil to the system.

"Lubrication Process Quantity (Piston Stroke Quantity)" value input box determines the count of lubrication.

"Manuel Lubrication Processing Time(s)" value determines the lubrication duration while it's controlling by manuel.

"Chain Lubrication Start Press Quantity" value determines the start action time of lubrication system. When count completed in this value box, the lubrication system starts to pump oil to the system.

6.1.19 OTHER ADJUSTMENT 2



"Form Analog Referance (bar)" value determines the referance of form analog.

"Unwinder Speed Referance (bar)" value adjusts the referance speed of unwinder system.

"Station Motor Speed Referance (Hz)" value determines all station's movement servo motor's referance speed.

"Upper Cutting Motor Speed Referance (Hz)" value determines the up cutting block's movement servo motor's speed referance.

"Wrapper Required Tension (kg)" value adjusts the tension required for the wrapper system.

"Conveyor Speed Referance (Hz)" value sets the movement speed referance of the conveyor system.

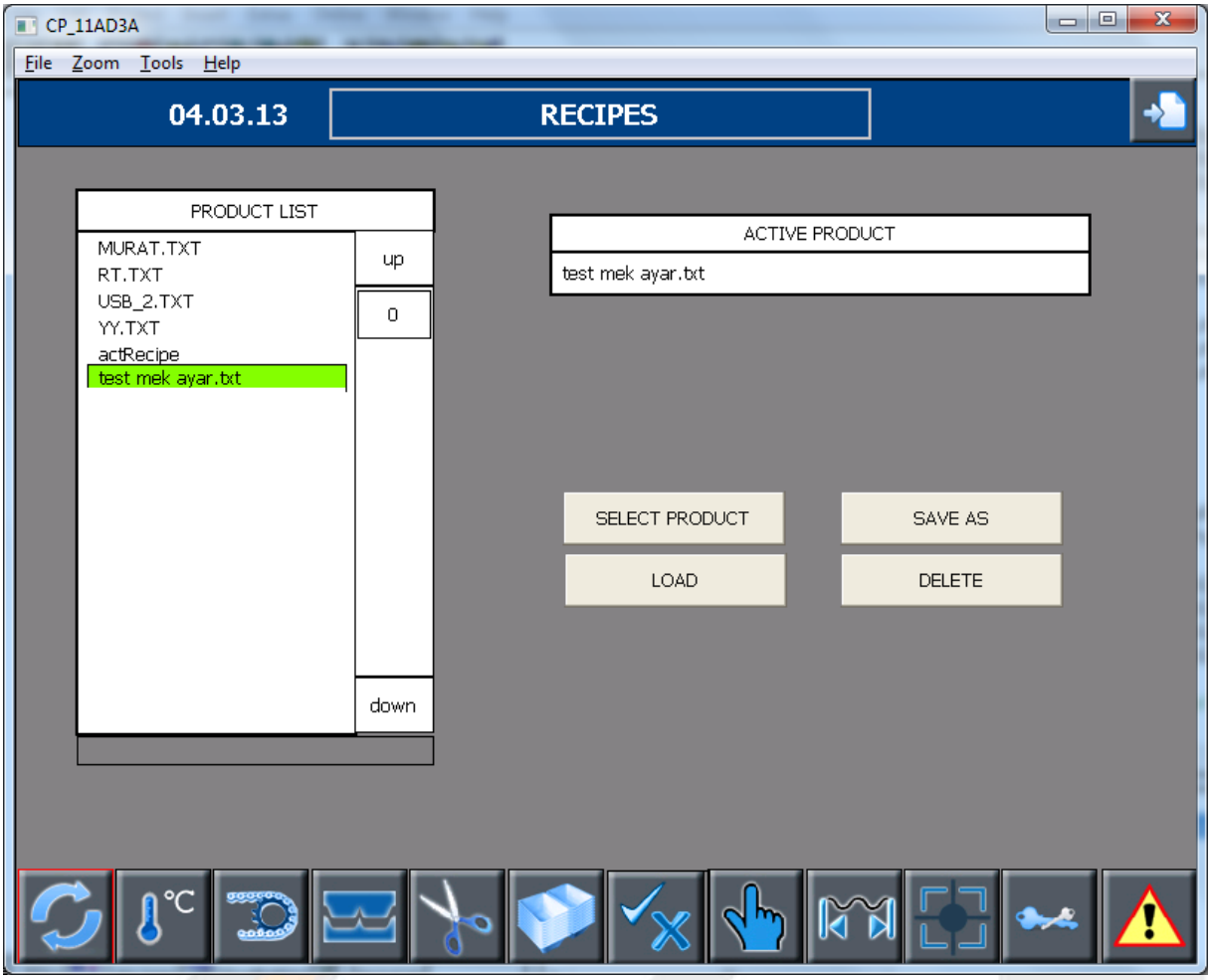
"Form of Passing an Empty Quantity" determines the empty quantity pass from forming station for each.

Date and time settings are on this page. After input for all date and time values, "Set Time" button have to be pressed to adjust the current date and time.

6.1.20 ALARM PAGE

All current and previously alarms and malfunctions that given by the machine can be seen on this page.

6.1.21 RECIPES



Each mould has its own settings. When the mould's settings are changed, must be redone. In order to deal with this situation and save all the settings, a page named recipe is constructed.

All the settings of a mould adjusted before can be saved with a given name and these settings can be re-uploaded to the memory when needed.

When the same mould is required, the pre-set adjustments are recalled easily.

Active product recorded settings can be seen by title "Active Product".

The list on the left of page includes previously recorded settings for each product.

“Product List” 400 recipes can be saved.

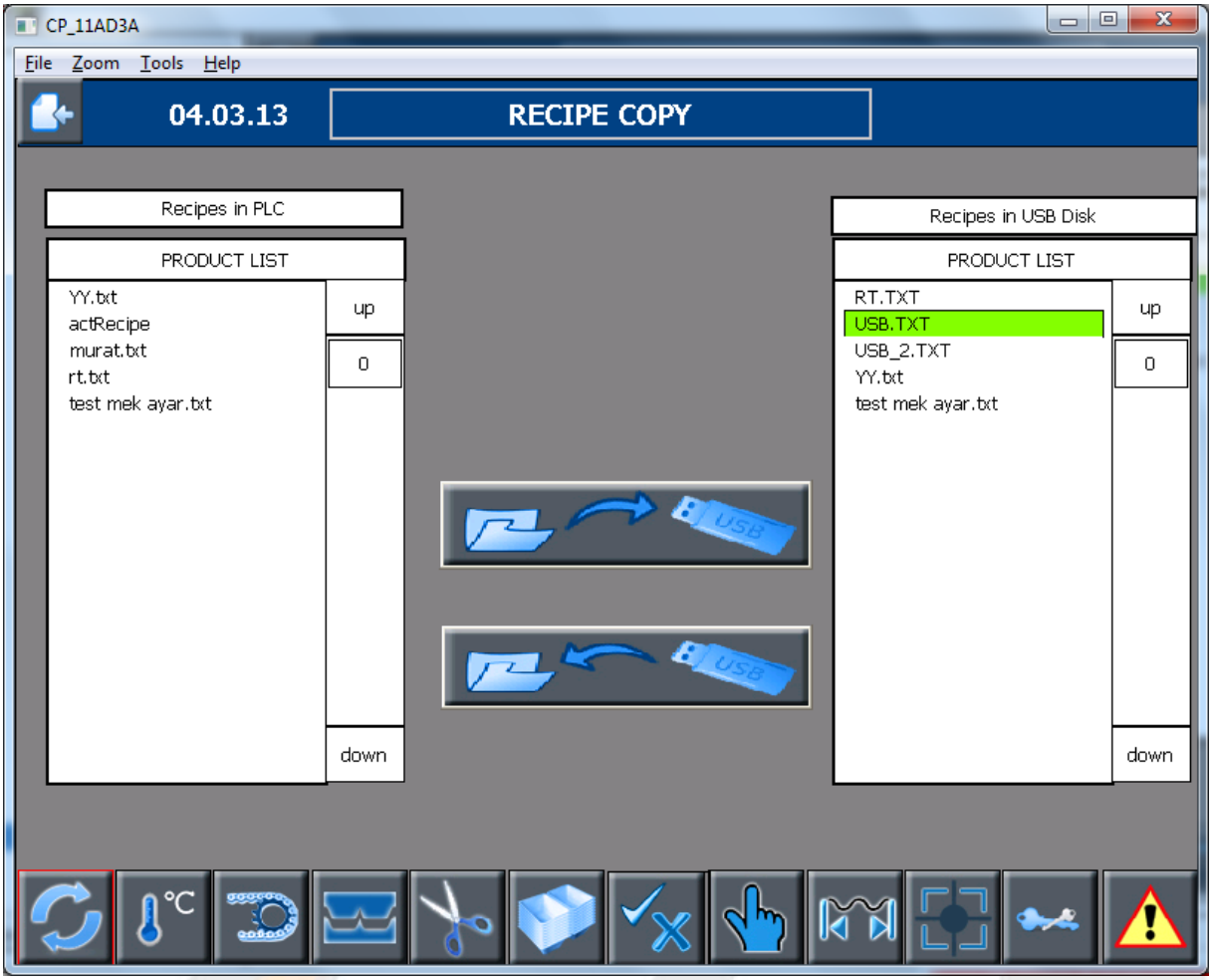
“Select Product” Product List, the mould to be run must be selected and carried to Active product section by pressing Select Product button.

“Load” by pressing mould Load button, the loading process is accomplished, when the square field on the lower left side of the screen is green.

“Save As” to change the actual values of the product’s recipe. It can be used to create another recipe for another product by chaning the product name and enter the Yes button. The steps must be done respectively.

“Delete” the unnecessary product recipes will be deleted.

6.1.22 RECIPES 2



Recipe Copy, to copy recipes from the machine to USB or from USB to machine. The list on the left side of the screen shows the list of the recipes in the machine, and on the right side of the screen shows the list of the recipes in the USB. The recipes can be carried by pressing the button in the middle of the screen.

6.2 OPERATOR PANEL

This chapter includes the buttons under the digital screen of the control panel with their explanations.

6.21.1 Manual - Auto (1)

When pushed once, the light is on and the machine turns into automatical settings. When pushed once more, the light turns off and it turns into manual settings. If the start button is not pushed within 15 seconds after switching the authomatic settings, it turns back into manual mode again.

6.21.2 Stop (2)

When pushed, the machine stops.

6.21.3 Start (3)

When pushed, the machine starts operating.

6.21.4 Chain (4)

When pushed, the chain system starts operating.

6.21.5 Forming (5)

When pushed, the forming station starts operating.

6.21.6 Cutting (6)

When pushed, the cutting station starts operating automatically.

6.21.7 Stacking (7)

When pushed, the stacking station starts operating automatically.

6.21.8 Buzzer (8)

This is the mechanism of the alarm sound.

6.21.9 Auxiliary Button (9)

If the stations are required to be moved manually, then the necessary manual movement button should be pushed while keeping this button pressed.

6.21.10 Emg. Plc Alarm Reset Button (10)

It resets the alarms to let the system operate. Just one push is enough.

6.21.11 Alarm Lamp (11)

It warns with a light in case of an emergency situation.

6.21.12 Chain Backward (12)

It checks the servo motor on the chain sled. It lets the chain move from the direction of scrap winding part to the direction of foil feeding part. When the button is pushed, the movement will continue without any stop. It does not work during the process of automatic settings.

6.21.13 Chain Forward (13)

It checks the servo motor on the chain sled. It lets the chain move from the direction of foil feeding part to the direction of scrap winding. The movement will continue without any stop. It does not work during the process of automatic settings.

6.21.14 Emergency Stop (14)

In case of a breakdown or error, this button ends the current process immediately. The machine stops operating no matter what it is doing. To cancel the emergency, it is enough to push the button and then rotate it in the arrow direction. As it may cause damage to the machine in heavy use, it should be used only in case of an emergency.

6.21.15 Form Top Up (15)

It provides the upward movement of the forming station. When pushed, the movement continues. Only operates in manual setting.

6.21.16 Form Top Down (16)

It provides the downward movement of the forming station. When pushed, the movement continues. Only operates in manual setting.

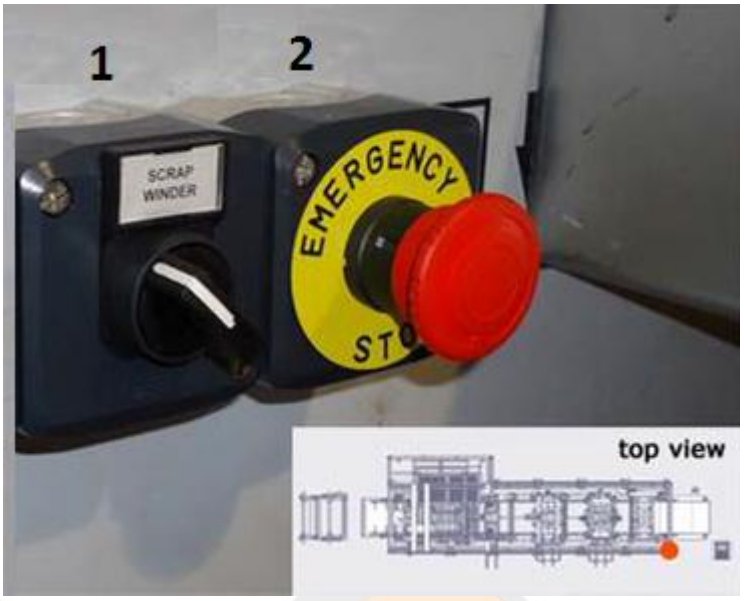
6.21.17 Form Below Up (17)

It provides the upward movement of the lower forming station. When pushed, the movement continues. Only operates in manual setting.

6.21.18 Form Below Down (18)

It provides the downward movement of the upper forming station. When pushed, the movement continues. Only operates in manual setting.

Unwinder Control Buttons

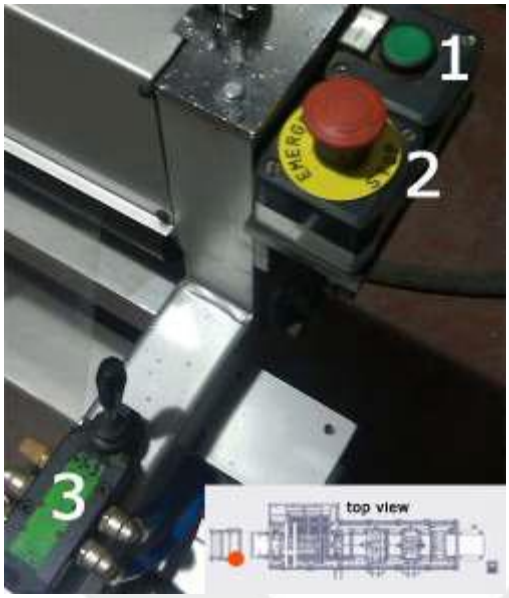


The first button has two levels. While this switch is at left position, unwinder works only at auto-working. If the switch is at right (second) position, the unwinder works continuously. The second button is an emergency stop button that stops the whole machine at an emergency situation.

Chain Control Buttons

First button moves the chain to forward continuously while pushed down. Second button moves the chain to backward continuously while pushed down. The third button is an emergency stop button that stops the whole machine at an emergency situation

Feeder Control Buttons



First button turns the sheet feeder continuously while been pushed down. Second button is an emergency stop button that stops the whole machine at an emergency situation. Third handle used for replacing sheet roll with a new one. While handle is at first position, it moves sheet feeder down with pneumatic pistons. While handle is at second position, it moves sheet feeder up with pneumatic pistons.

CHAPTER 7

7.MAINTENANCE

7.1 BEFORE MAINTENANCE

Before maintenance and repair operations in the machine, the machine must be stopped and energy disconnection completely must be assured. The Emergency stop button must be switched on during the maintenance operation and the lock-key must be carried by the responsible staff for the maintenance.

7.2 DAILY MAINTENANCE

Eccentric sleeve bearings, chain guides and moving block bush are lubricated automatically with central lubrication system (Daily Maintenance for machines without automatic lubrication system).

7.3 WEEKLY MAINTENANCE

1) The casting arms on the cam block of the machine must be checked optically weekly. In case of determining appropriateness, the machine shall not be run and precautions must be activated according to the manual – hand book of the machine.
2) General cleaning of the machine must be done minimum weekly. Dusty zones of the machine must be cleaned with blowgun.
3) The air filters of the fan in the electrical cabinet must be cleaned with air-blowgun on weekly basis. The filters not cleaned regularly are chocked; the air circulation will be reduced causing parts damage due to overheating.
4) There will be water logging (water accumulation) in the air tanks on the top of the machine. The water in the air tank has to be removed once a week to utilize the air tank with maximum efficiency.

7.4 MONTHLY MAINTENANCE

1) After a month of running the machine, the pneumatic systems have to be checked. Any possible air leakage on the pistons must be checked. Pneumatic valves must be checked for their functionality. The level of the conditioning lubricant must be checked. Lubricant must be added in case of any reduction under level.
2) Electrical installations must be checked once a month by qualified specialists. Motors have to be checked against overheating. Moving part sensors and magnetic sensors of the pistons must be checked.

7.5 YEARLY MAINTENANCE

1) Annual maintenance will be done by Yeniyurt service team. The machine will be checked for all parts and its optimum efficient functionality. Any damaged and worn parts are to be replaced.
2) Ventilation filters in the electrical cabinet must be changed once a year. Otherwise electronic parts (products) can be damaged.

7.6 AFTER MAINTENANCE

Please do not forget any loose or not belonging parts in the unit after the maintenance process is finished.

7.7 MAINTENANCE PLAN

Period	To Do	Consumables
Every Day	General check of moving parts for stability and the whole machine must be done.	-
Every Two Days	Eccentric sleeve bearings, chain guides and moving block bushes must be lubricated every two weeks. (In automatically lubricated machines, this process done by automatic lubrication system)	-
Every Week	The casting arms on the cam block must be checked for stability.	-
Every Week	General cleaning of the machine must be done and dusty zones of the machine must be cleared with blowgun.	-
Every Week	Ventilation filters on electric cabinet must be cleared with air.	-
Every Week	There will be water logging (water accumulation) in the air tanks on the top of the machine. This accumulation hast to be removed to utilize the air tank with maximum efficiency.	-
Every Week	Lubricant level from indicator of vacuum pump must be check and in case of low lubricant indicate, lubricant addition must be done.	Shell Vitrea 100 Circulation Lubricant
Every Month	Pneumatic systems have to be checked. Any possible air leakage on pistons and functionality of pneumatic valves must be checked. Lubricant must be added in case of any reduction of conditioning lubricant level.	Conditioning Lubricant

Every Month	Electrical installations must be checked by qualified specialists. Motors have to be checked against overheating. Moving part sensors and magnetic sensors of the pistons must be checked.	-
Every Month	Vacuum tank have to be checked for its functionality. Vacuum fitler must be cleared and lubricant level has to be checked. In case of any low level lubricant, lubricant addition must be done.	Shell Vitrea 100 Circulation Lubricant
Every Year	Ventilation filters on the electric cabinet have to be replaced with new ones. Otherwise electric parts (products) can be damaged (overheating, short circuit, etc.)	-
Every Year	Any moving parts and the whole machine have to be checked for functionality and optimum efficiency by Yeniyurt service team. Any damaged and worn parts have to be replaced.	-

7.8 CONSUMABLES GIVEN WITH MACHINE

o Mini Relay (2 pieces)

o M12 Proximity Sensor (2 pieces)

o M8 Proximity Sensor (2 pieces)

o Magnetic Piston Sensor (2 pieces)

o 40A Fuse (2 pieces)

o Tools Kit

CHAPTER 8

8. TROUBLESHOOTING

8.1 MALFUNCTIONS AND SOLUTIONS

The list of any possible breakdowns is given in a chart below. Each malfunction, reason and solution is explained. When a malfunction occurs, it should be searched in this list for a solution. If the stated solution does not function, then you should contact with the firm.

MALFUNCTION	REASON	SOLUTION
The alarm window alarms that " The Emergency Stop is Pressed"	One or more emergency stop buttons are pressed or because emergency stop button circuit is in series, a short circuit or disconnection occur.	If the machine is ready to operate, the pressed emergency stop buttons are pushed. If none of the buttons are pressed, a short circuit or disconnection might have occured. Contact with the firm.
The alarm window indicates "The Heating Oven Cannot Continue"	The heating oven in the machine cannot move forth. The pistol providing this movement or the limit switch can be malfunctioning. Or the oven might be jammed. Also, the valve of the pistol providing the movement can be out of order or the pressure of the air coming to the machine is not sufficient.	Check the pressure of the air coming into the machine. The oven should be controlled if got stuck. The moving pan is moved manually by using the menu on the control panel – manuel settings and via the leds the sensors are controlled if they are operating properly. If the problem is not solved, contact with the firm.
The alarm window indicates "The Bumper Cannot Go Up"	The upper forming station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order. The bumper encoder value might be entered wrong. The buffer might	Check the pressure of the air coming into the machine. The upper forming station might be disassembled to see if there is any jam. The led buttons can be checked if they are on/off. The bumper encoder values should be checked. If the problem is not solved,

	not be chosen from the options page.	contact with the firm.
The alarm window indicates “The Bumper Cannot Go Down”	The lower forming station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order. The bumper encoder value might be entered wrong. The buffer might not be chosen from the options page.	Check the pressure of the air coming into the machine. The lower forming station might be disassembled to see if there is any jam. The led buttons can be checked if they are on/off. The bumper encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Lower Stacking 1. Stage Cannot Go Up”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Lower Stacking 1. Stage Cannot Go Down”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Lower Stacking 2. Stage Cannot Go Up”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Lower Stacking 2. Stage Cannot Go Down”	The stacking station might be jammed. There might not be enough air pressure in the machine. The	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the

	bumper pistol or pistol limit switch can be out of order.	problem is not solved, contact with the firm.
The alarm window indicates “The Upper Stacking Stage Cannot Go Up”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Upper Stacking Stage Cannot Go Down”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. The stacking encoder values should be checked. If the problem is not solved, contact with the firm.
The alarm window indicates “The Sweeper Cannot Go Forward”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. If the problem is not solved, contact with the firm.
The alarm window indicates “The Sweeper Cannot Go Backward”	The stacking station might be jammed. There might not be enough air pressure in the machine. The bumper pistol or pistol limit switch can be out of order.	Check the pressure of the air coming into the machine. If the problem is not solved, contact with the firm.
The alarm window indicates “The Servo Motor Malfunction”	The servo motor driver might be out of order. There might be an electrical or mechanical malfunction.	By controlling the malfunction status, the technical service should be called.
The alarm window	There might be a short	The vacuum motor

indicates “The Vacuum Motor Thermic Malfunction”	circuit or over current in the vacuum motor or there might be a mechanical problem.	thermic driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Scrap Winding Motor Malfunction”	There might be a malfunction in the scrap winding motor. There might be a mechanical or electronic problem.	The scrap winding motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Upper Forming Motor Malfunction ”	There might be a malfunction in the motor. There might be a mechanical or electronic problem.	The upper motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Lower Forming Motor Malfunction ”	There might be a malfunction in the motor. There might be a mechanical or electronic problem.	The lower motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Upper Cutting Motor Malfunction ”	There might be a malfunction in the motor. There might be a mechanical or electronic problem.	The upper motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Lower Cutting Motor Malfunction ”	There might be a malfunction in the motor. There might be a mechanical or electronic problem.	The upper motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Chain Servo Motor Malfunction”	There might be a malfunction in the motor driver. There might be a mechanical or electronic problem in servo.	The servo motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “1. Front Cover Switch”	1. front cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the 1st front cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “2. Front Cover Switch”	2. front cover switch is not detected. The cover is not	Check if the 2nd front cover is closed. If is not closed, close it. If the problem continues, the

	closed or the switch is not functioning properly.	switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “3. Front Cover Switch”	3. front cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the 3rd front cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “4. Front Cover Switch”	4. front cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the 4th front cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “1. Back Cover Switch”	1. back cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the 1st back cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “2. Back Cover Switch”	2. back cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the 2nd back cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “Back Cover Switch”	Back cover switch is not detected. The cover is not closed or the switch is not functioning properly.	Check if the back cover is closed. If is not closed, close it. If the problem continues, the switch might be out of order or the cables are damaged. Please contact with the firm.
The alarm window indicates “The Thermocouple is	One of the resistances on the heating pan or cutting knife is damaged or the	The terminals of tips of the cables should be controlled. Please contact

Disconnected”	heat thermometer is out of order.	with the firm, if the problem continues.
The alarm window indicates “Extremely Hot”	One of the resistances on the heating pan or cutting knife is damaged or the heat thermometer is out of order.	The terminals of tips of the cables should be controlled. Please contact with the firm, if the problem continues.
The alarm window indicates “The Good Run Out”	The material in the sheet feeding unit might run out. It he material is not expired, the switch detecting the roll up might not be operating properly.	If the good runs out, put the new one. If it is not and the switch has a problem, please contact with the firm.
The alarm window indicates “The Station Setting Motor Malfunction”	The station setting motor might be out of order. There might be a mechanical or electrical problem.	The station motor driver in the electrical panel should be checked and the technical service should be called.
The alarm window indicates “The Material Has Melted”	Due to the high temperature, the material might melt and can cause sags between the pans.	Push the alarm reset button to decrease the temperature. Please contact with the firm, if the problem continues.
The alarm window indicates “The Entrance Stretching Motor Thermic Malfunction”	There might be a short circuit or over current in the entrance stretching motor. Or there might be a mechanical problem in the motor.	The entrance stretching motor thermic should be checked and the technical service should be called.
The alarm window indicates “The Middle Stretching Motor Thermic Malfunction”	There might be a short circuit or over current in the middle stretching motor. Or there might be a mechanical problem in the motor.	The middle stretching motor thermic should be checked and the technical service should be called.
The alarm window indicates “The Output Stretching Motor Thermic Malfunction”	There might be a short circuit or over current in the output stretching motor. Or there might be	The output stretching motor thermic should be checked and the technical service should be

	a mechanical problem in the motor.	called.
The alarm window indicates “Cutting Stacking Crush”	The stations are too close to each other.	The problem can be solved by bringing each station to a safe distance.
The alarm window indicates “The Stretching Motor s are Reverse”	This problem occurs when the stretching motors’ phase directions are reverse or one of them does not work properly due to a mechanical or electrical malfunction.	The directions of the phases should be checked, namely the motor should be checked if it is rotating. The set values of the entrance, middle and output stretches are equal. If the problem continues, please contact with the technical service.

CHAPTER 9

9.WASTE MATERIAL DISPOSAL

9.1 WASTE MATERIAL DISPOSAL

The customer firm is responsible for eliminating all the waste materials if a recycling system is not used within the frame of the law and legislation of the country where the machine operates.

Temporary waste storing operation can be done to some extent based on the law and legislation of the country where the machine operates and recycling must be done intermittently.

The temporary storage area must not react chemically with any substance in it. The ones with toxic substance must be labeled for danger.

1- FLAMMABLE SUBSTANCE
2- POISONOUS or TOXIC SUBSTANCE
3- POIGNANT AND CUTTER MATERIAL
4- COMBUSTIBLE SUBSTANCE
5- INFLAMMABLE SUBSTANCE

Disposal of the waste materials must be done by expert firms with certificates.

The firm conducting transport must compromise with certificated technical staff.

CHAPTER 10

10. SPARE PART REQUESTS AND TECHNICAL SUPPORT

10.1 SPARE PARTS AND TECHNICAL SUPPORT PROCEDURE

The ultimate user customer can demand original spare parts for the machine maintenance, repairmen, security and performance of the machine.

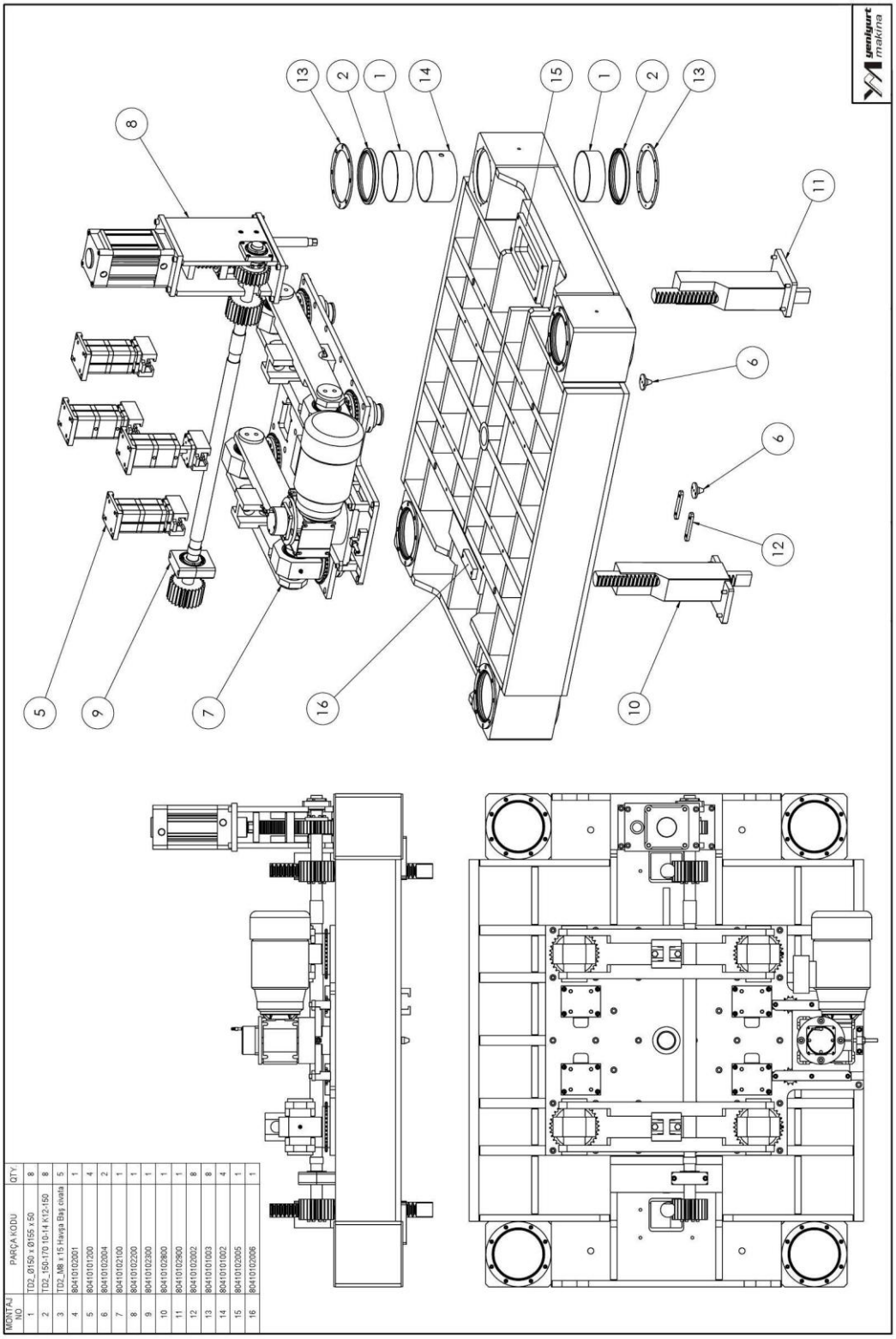
Although the information on general assembly and disassembly exist in this booklet, it is advised to do service issues by Yeniyurt Machine employees. Also, all the technical interferences can cause the cancellation of the warranty.

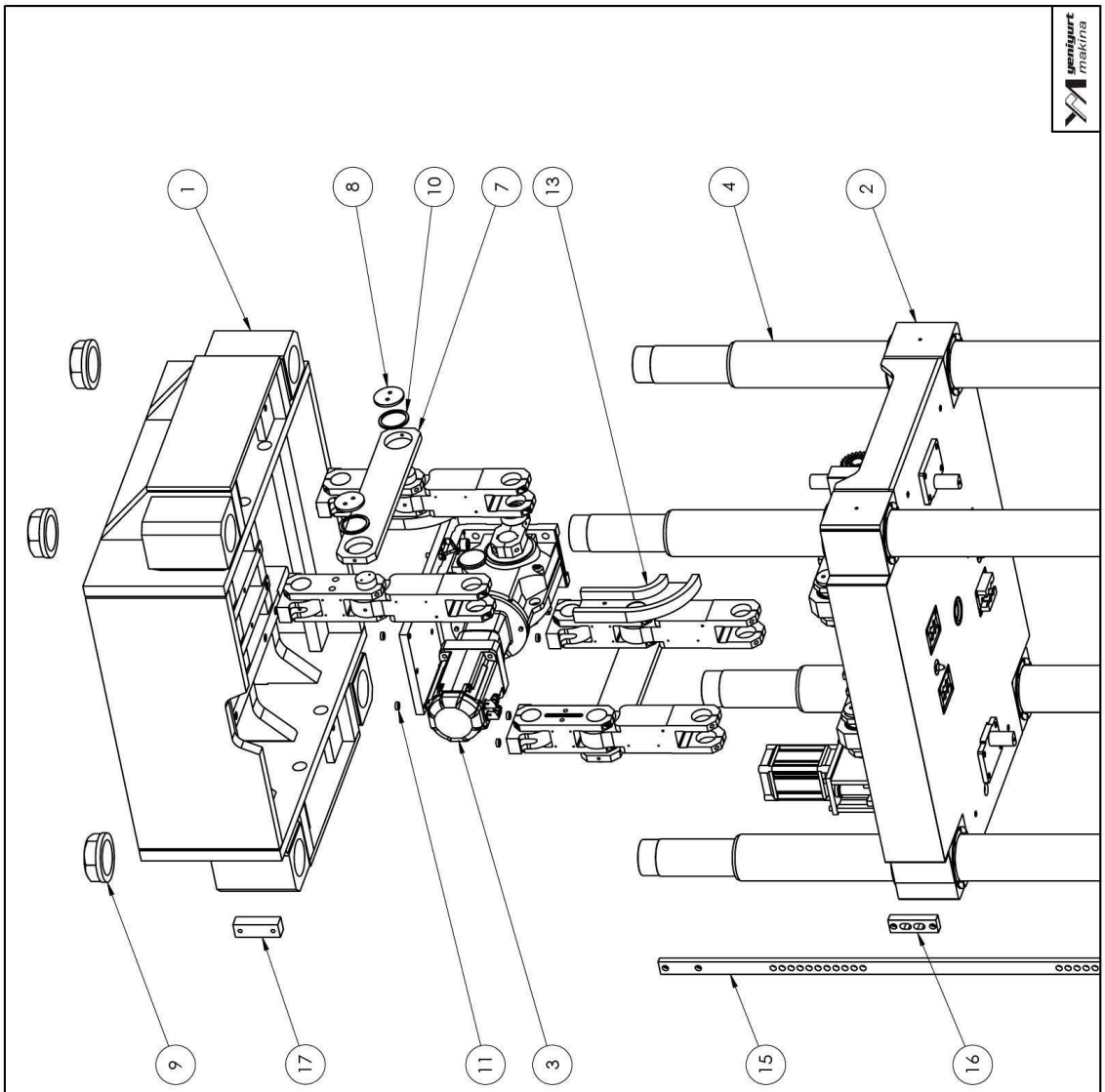
The information written below must be submitted clearly for technical service demands.

- The client firm information
- The name, surname and address of the
- The code of the part (if possible)
- The explanation of the part and the photo of it if possible
- The quantity

With all these information, the demand can be asked to the any contact information below:

10.2 FORMING SPARE PARTS LIST





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3	80410104000	1
4	80410100005	4
5	80410103100	2
6	80410103000	2
7	80410100011	2
8	80410100010	4
9	80410100008	4
10	80410100009	4
11	80220230003	12
12	80300106000	5
13	80410100007	1
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15	80320500010	1
16	80410100012	1
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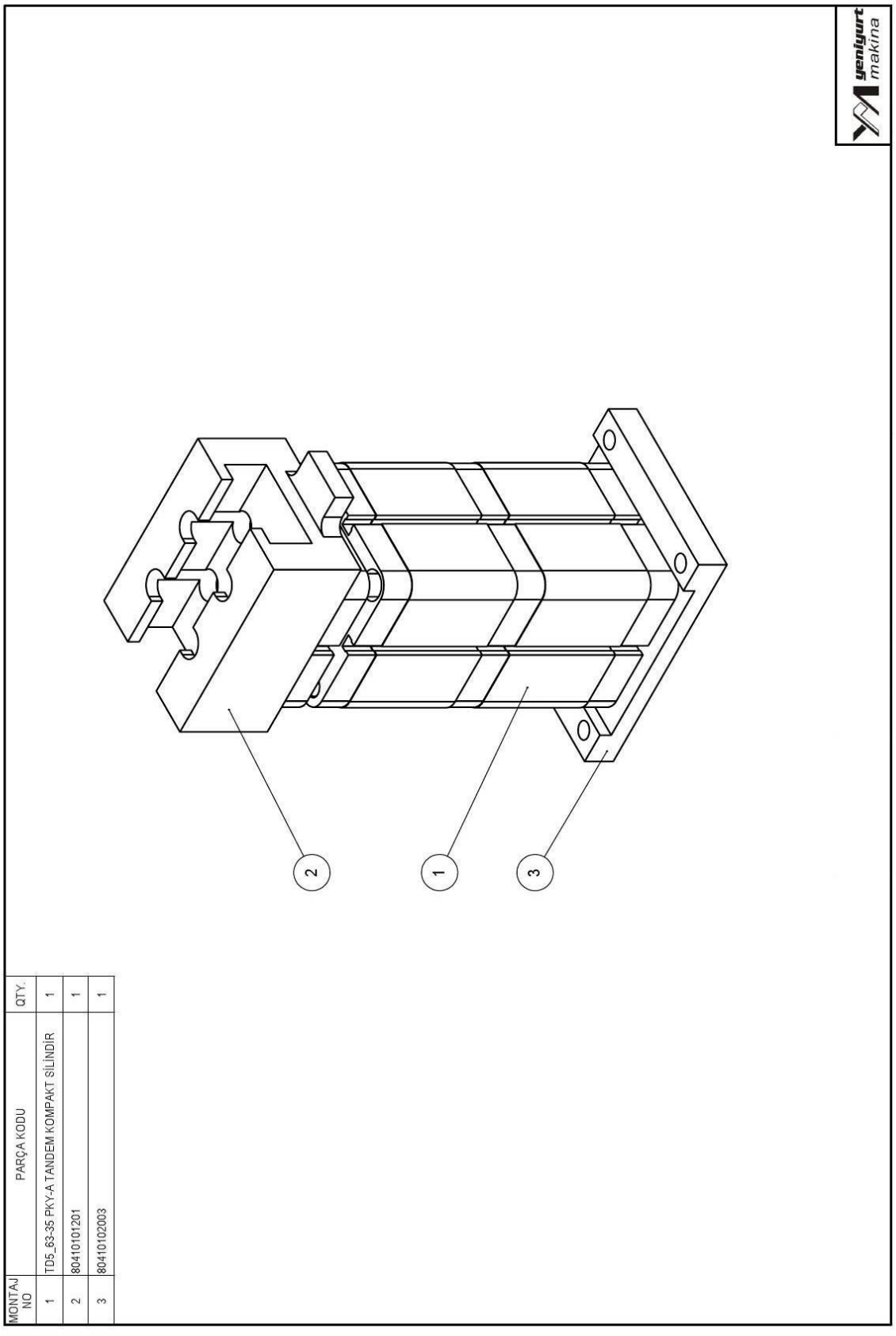
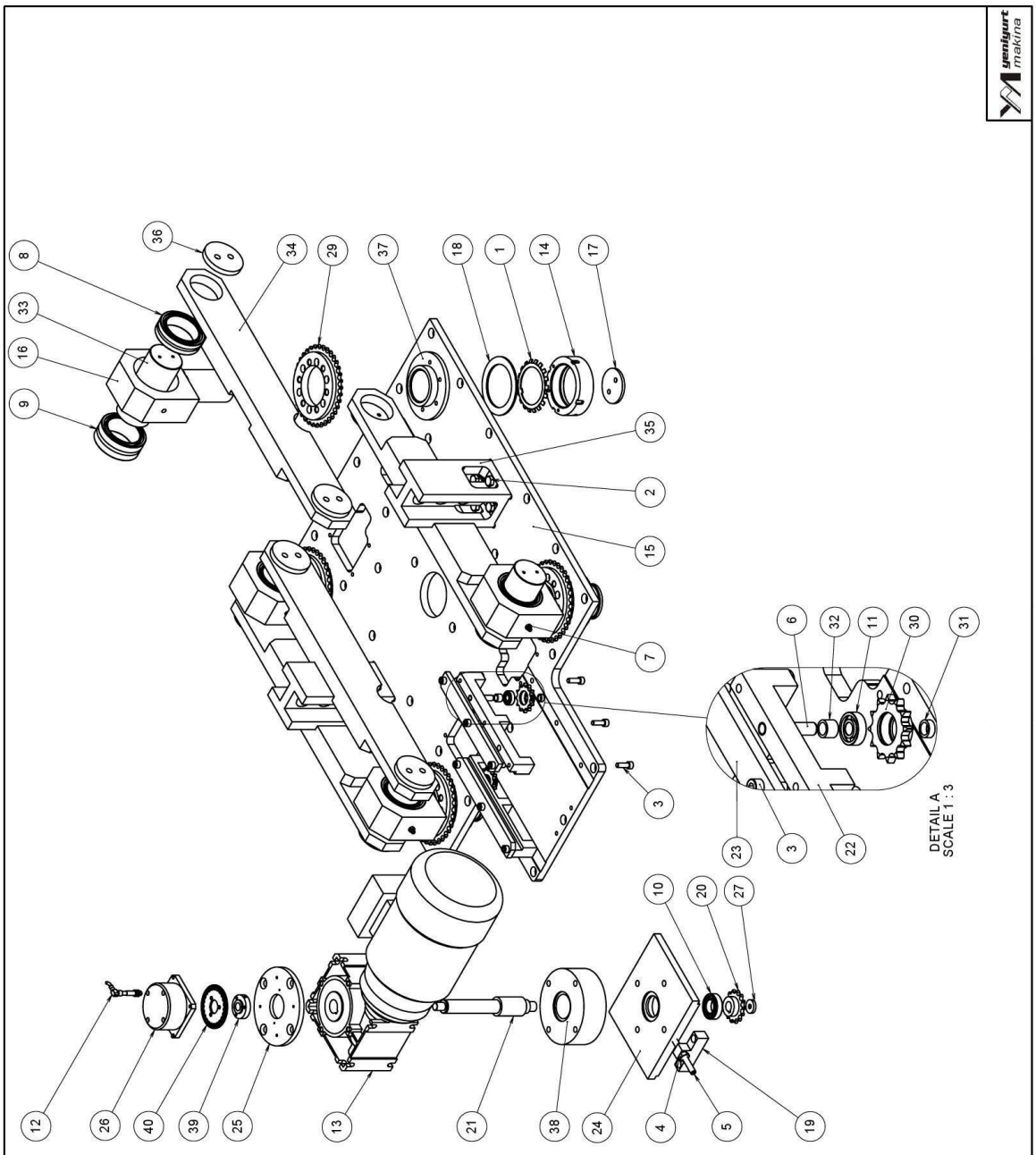
18	80410100014	1



MONTAJ NO	PARÇA KODU	QTY.
1	TD5_63-35 PKY-A TANDEM KOMPAKT SİLİNDİR	1
2	80410101201	1
3	80410102003	1



MONTAJ NO	PARÇA KODU	ADET
1	TD2_M14 emniyet saci (yildiz pul)	1
2	TD2_M10 x 35 alliköge civata	8
3	TD2_M8 x 25 imbus civata	12
4	TD2_M10 somun	1
5	TD2_M10 x 50 Setskur	1
6	TD2_Ø10 x 50	2
7	TD5_1-8 grasörlük	2
8	TD2_NKJ 65-25 iğneli rulman	4
9	TD2_NKJ 65-35 iğneli rulman	4
10	TD2_6005 Rulman	1
11	TD2_6000 Rulman	2
12	TD6_M8 proximity switch	1
13	TD2_SK1SI63 NORD	1
14	80410102112	4
15	80410102101	1
16	80410102102	4
17	80410102104	4
18	80410102103	4
19	80410102119	1
20	80400112005	1
21	80410102111	1
22	80410102110	2
23	80410112011	2
24	80410102109	1
25	80220304104	1
26	80300571002	1
27	80220232015	1
28	80090100025	4
29	80410102106	4
30	80400112012	2
31	80400112014	2
32	80400112015	2
33	80410102107	4
34	80410102116	4
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37	80410102105	4
38	80410102118	1
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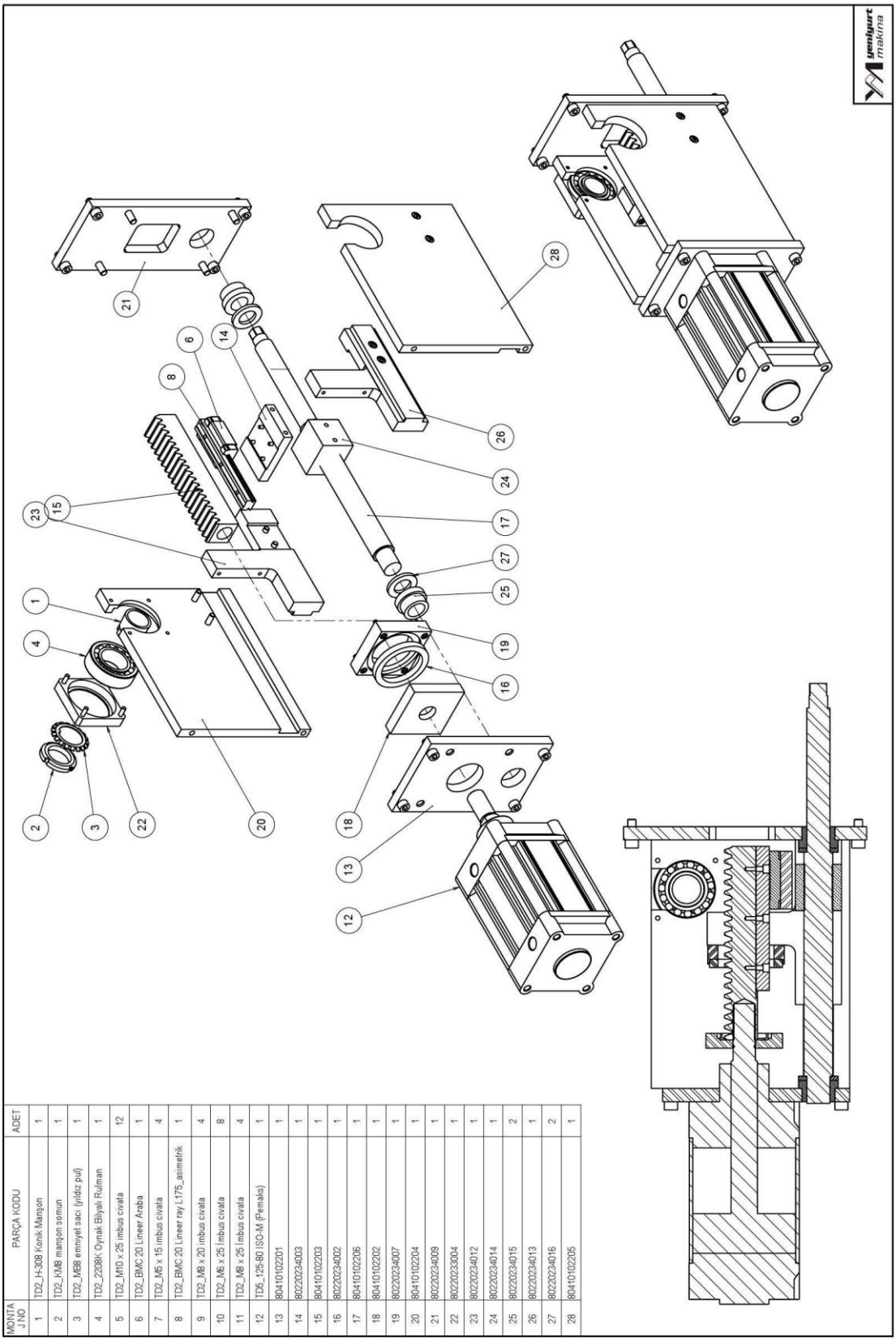

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1	TD2_H-308 Konik Manşon	1
2	TD2_KM8 manşon somun	1
3	TD2_MB8 emniyet saci (yildiz pul)	1
4	TD2_2308K Oynak Bilyali Rulman	1
5	TD2_M10 x 25 imbus civata	12
6	TD2_BMC 20 Lineer Araba	1
7	TD2_M5 x 15 imbus civata	4
8	TD2_BMC 20 Lineer ray L175_asimetrik	1
9	TD2_M8 x 20 imbus civata	4
10	TD2_M5 x 25 imbus civata	8
11	TD2_M8 x 25 imbus civata	4
12	TD5_125-80 ISO-M (Pemaks)	1
13	80410102201	1
14	80220234003	1
15	80410102203	1
16	80220234002	1
17	80410102206	1
18	80410102202	1
19	80220234007	1
20	80410102204	1
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22	80220233004	1
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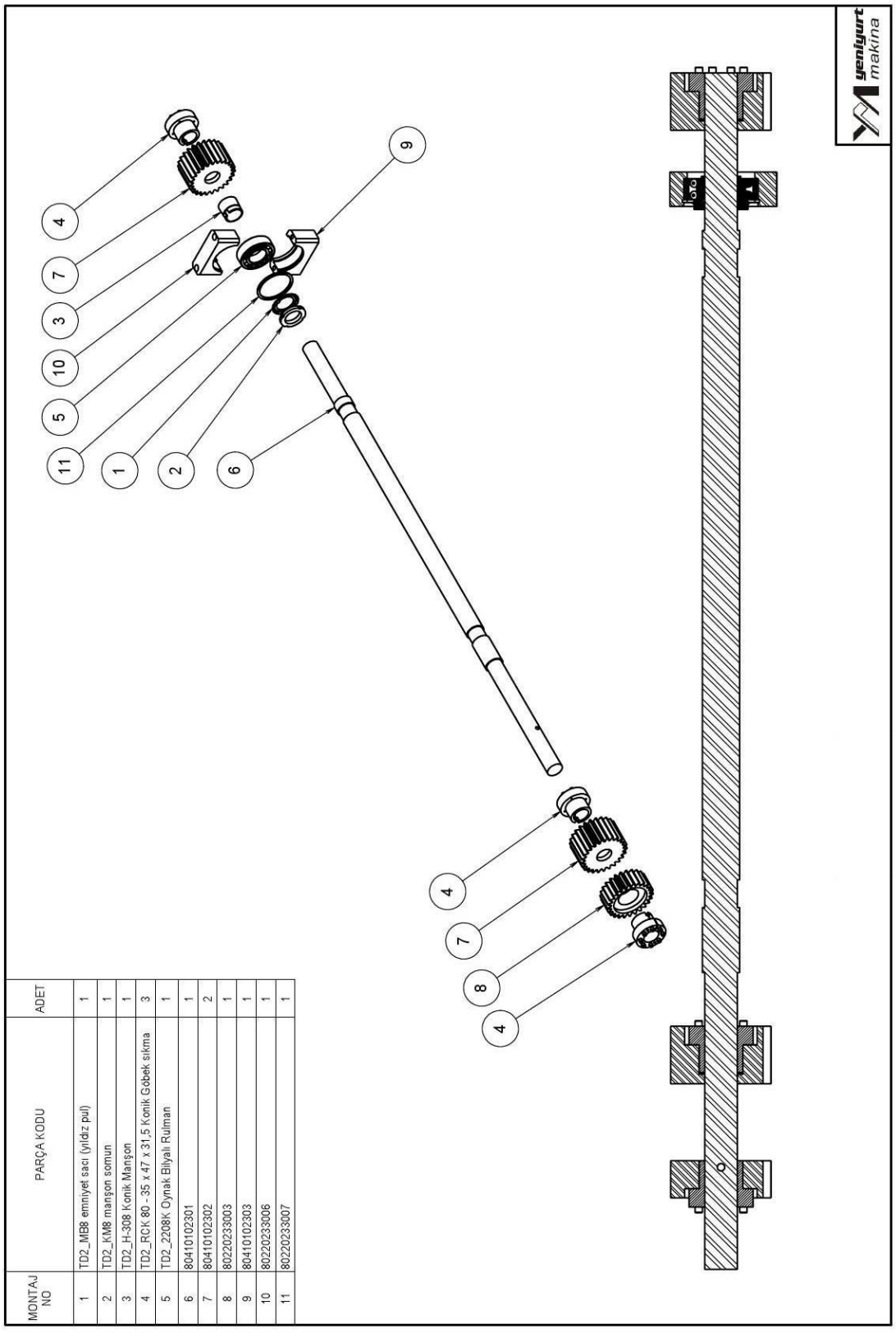

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1	TD2_M88 emniyet sacı (yıldız pul)	1
2	TD2_KM8 manşon somun	1
3	TD2_H-308 Konik Manşon	1
4	TD2_RCK 80 - 35 x 47 x 31,5 Konik Göbek sıkma	3
5	TD2_2208K Oynak Bilyalı Rulman	1
6	80410102301	1
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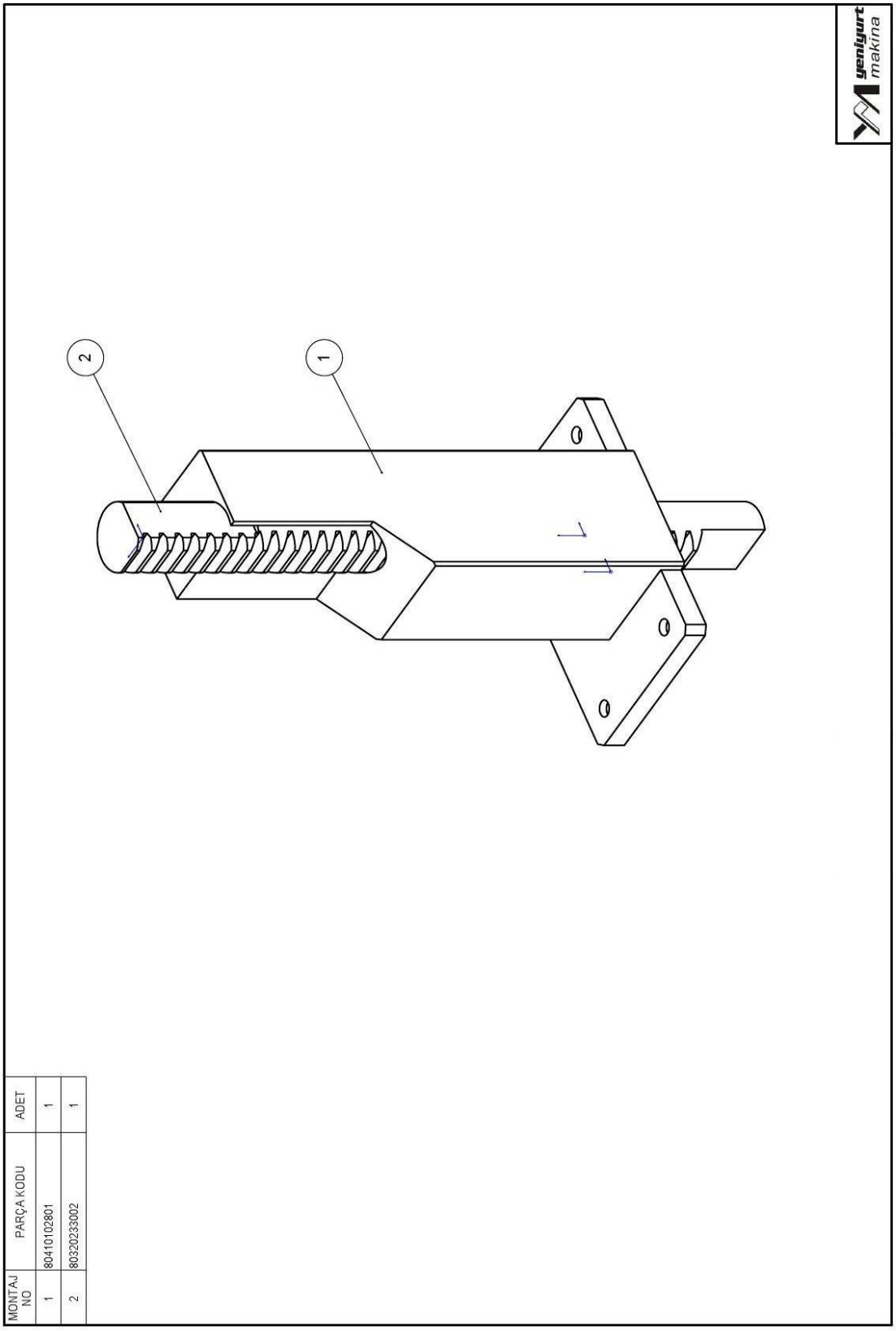

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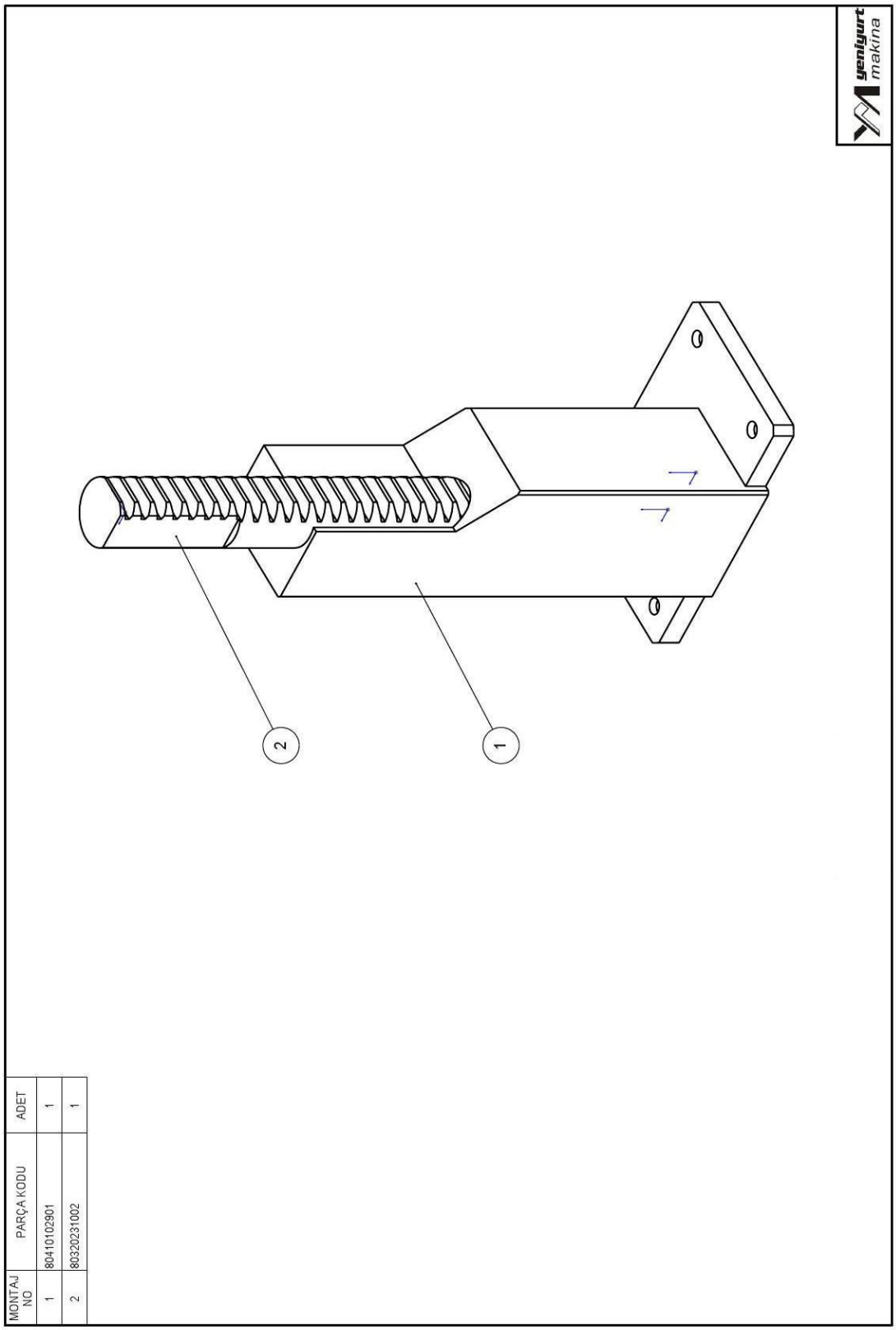

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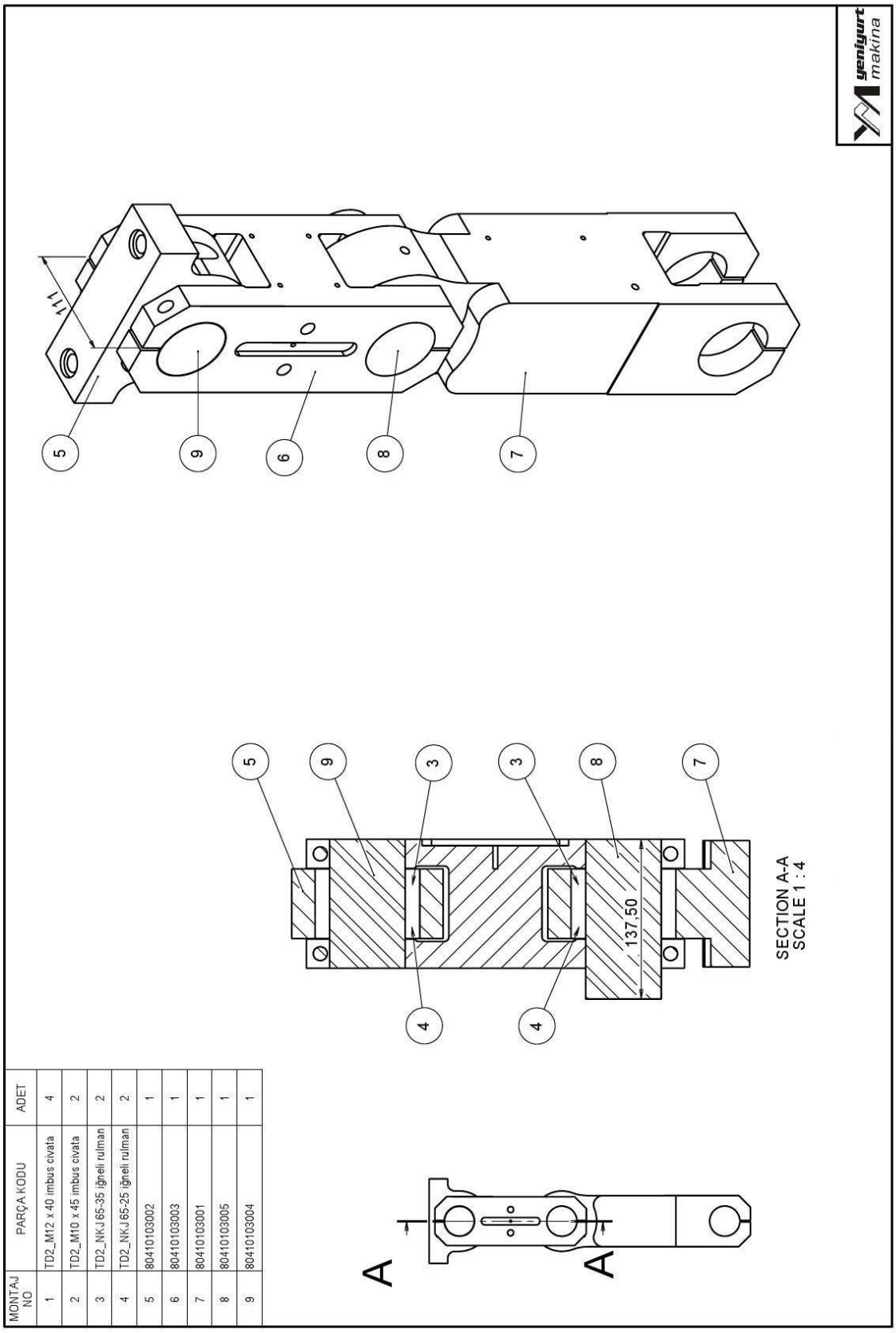

MONTAJ NO	PARÇA KODU	ADET
1	TD2_M12 x 40 imbus civata	4
2	TD2_M10 x 45 imbus civata	2
3	TD2_NKJ 65-35 iğneli rulman	2
4	TD2_NKJ 65-25 iğneli rulman	2
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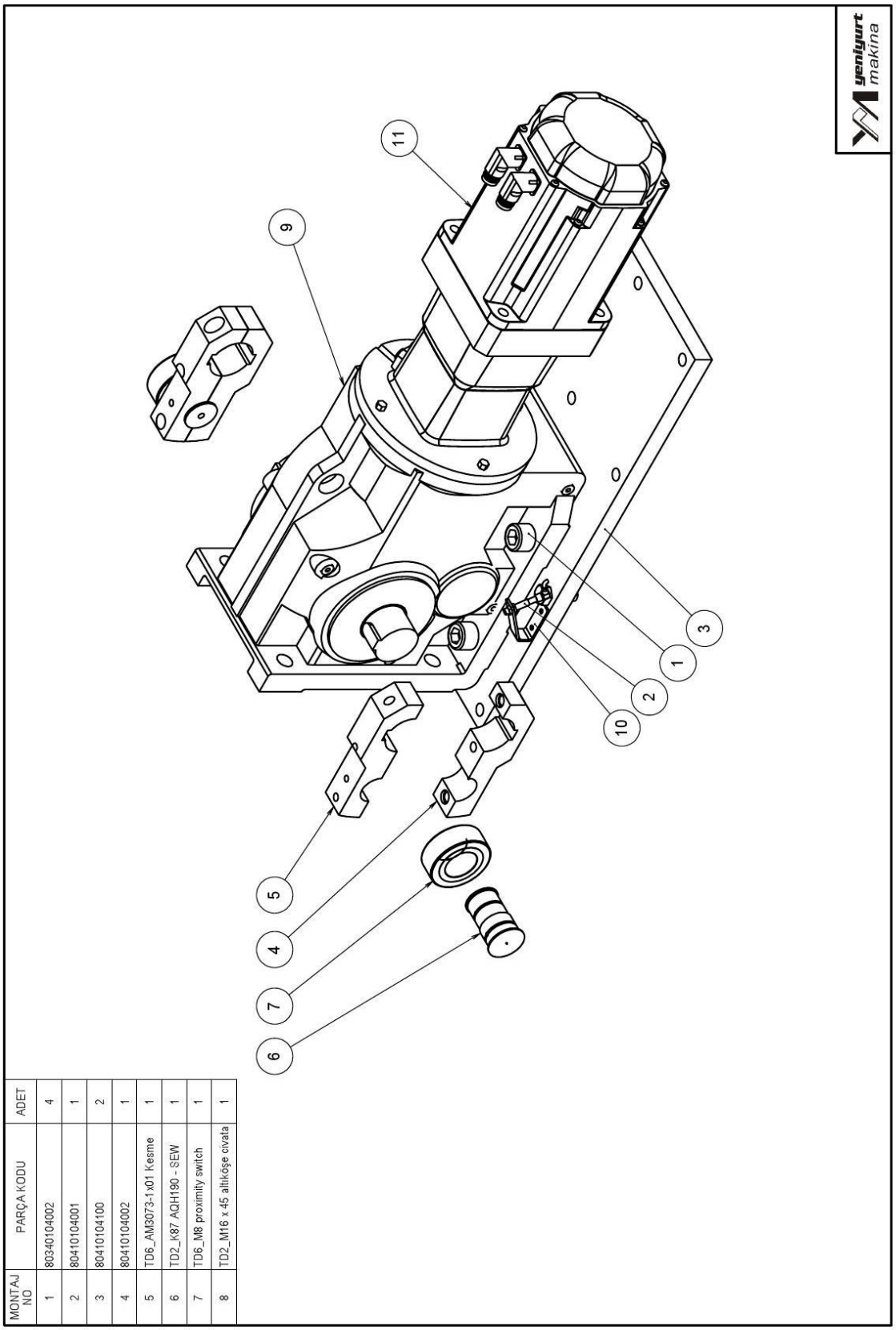

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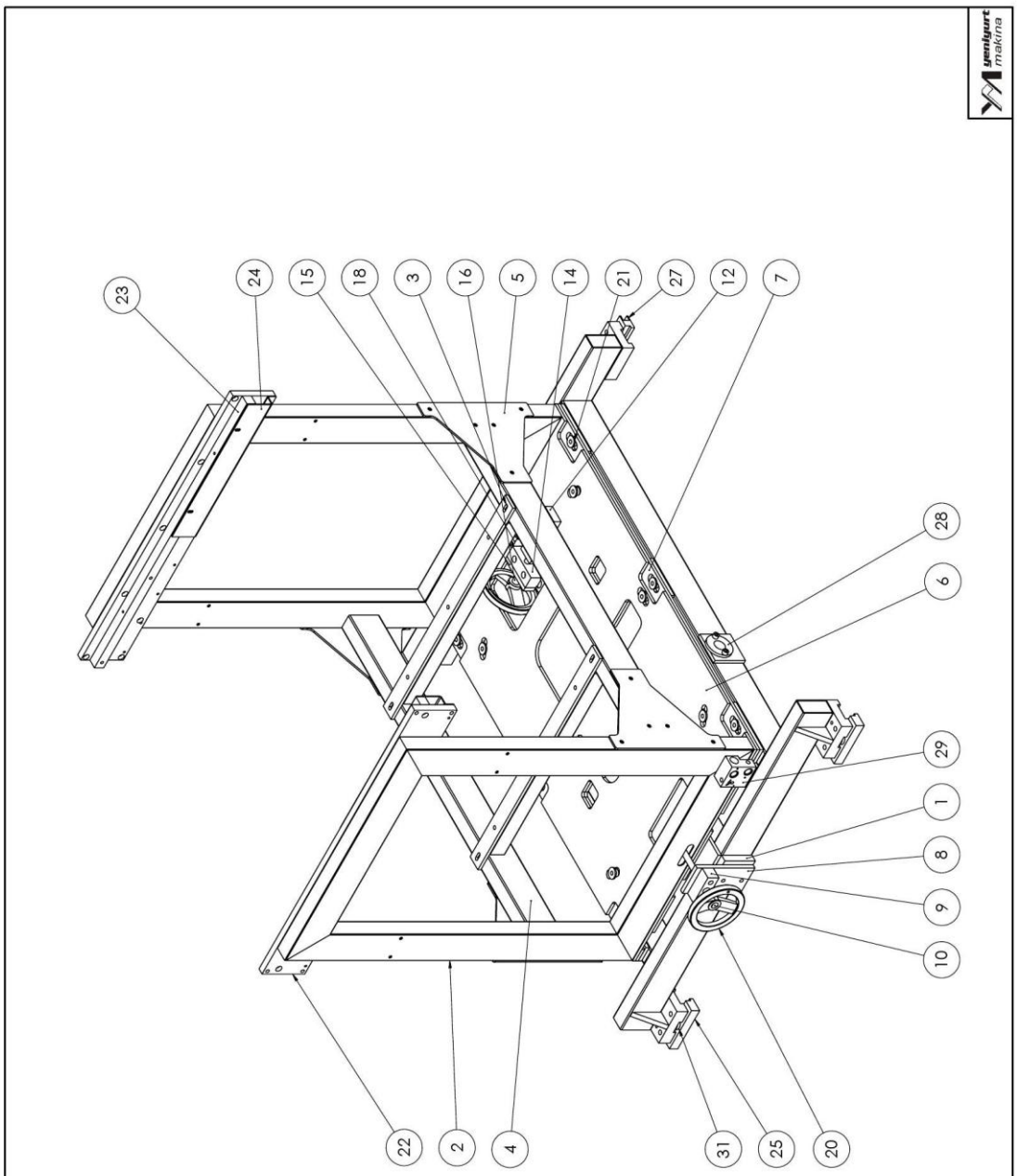
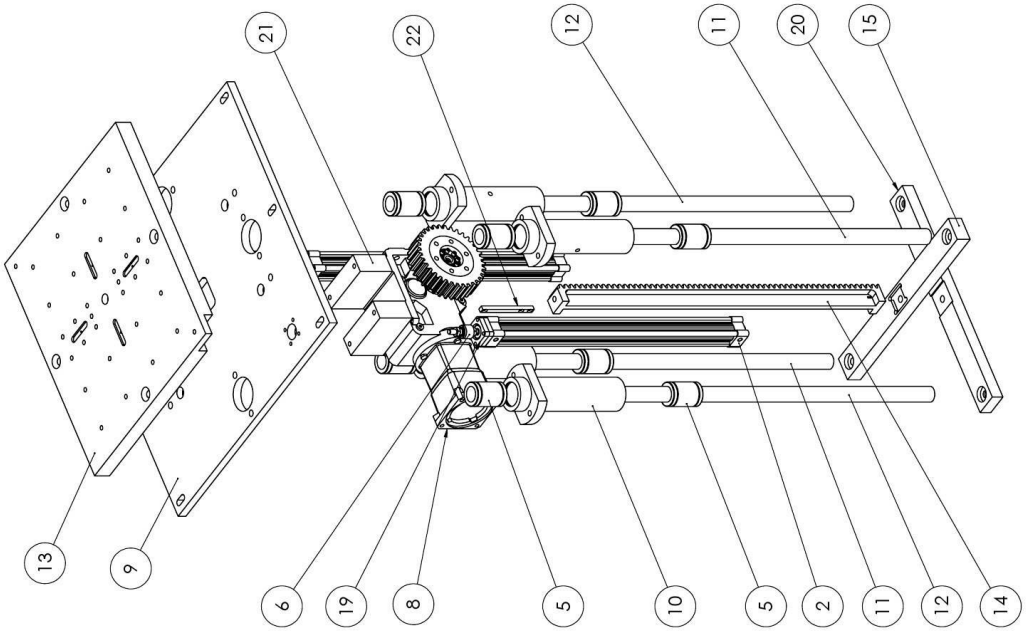
2	80410104001	1
3	80410104100	2
4	80410104002	1
5	TD6_AM3073-1x01 Kesme	1
6	TD2_K87 AQH190 - SEW	1
7	TD6_M8 proximity switch	1
8	TD2_M16 x 45 altıköşe civata	1

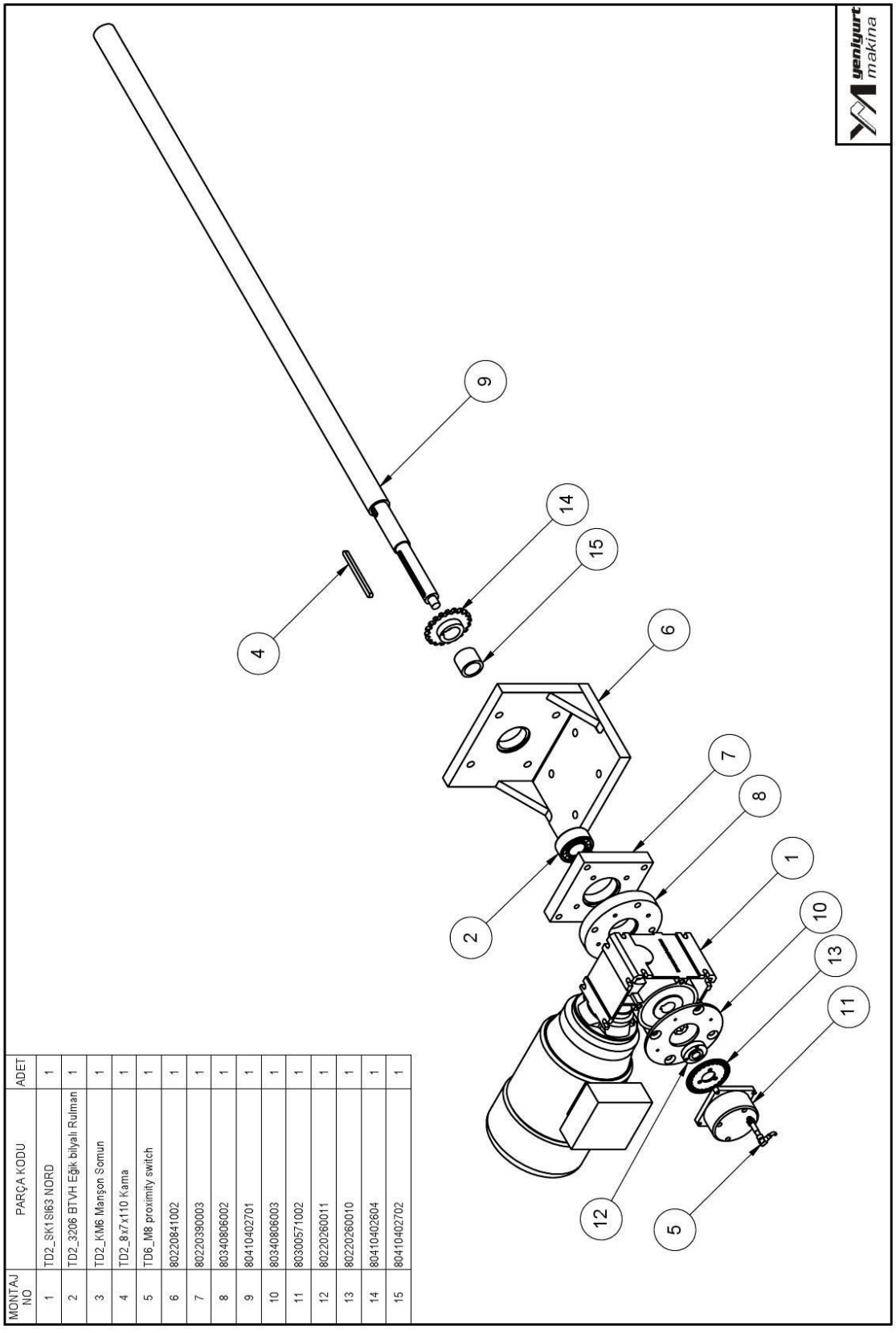
10.3 STACKING SPARE PARTS LIST



MONTAJ NO	PARÇA KODU	ADET
1	80340801003	1
2	80410801001	2
3	80340801002	2
4	80340801004	2
5	80220810006	4
6	80340801006	1
7	80340801005	1
8	80220810009	1
9	80220810017	1
10	80340801010	1
11	80220810019	1
12	80220810010	1
13	80220810011	1
14	80220810012	1
15	80220810013	1
16	80220810014	1
17	80220810020	1
18	80220810015	2
19	80220810016	2
20	80150510013	2
21	80220810023	12
22	80410801007	2
23	80410801009	2
24	80340800003	2
25	80220800008	2
26	80220300008	1
27	80220300033	1
28	80090800011	1
29	80410800010	1
30	TD2_M10 x 20 imbus civata	2
31	TD2_6002 Rulman	4

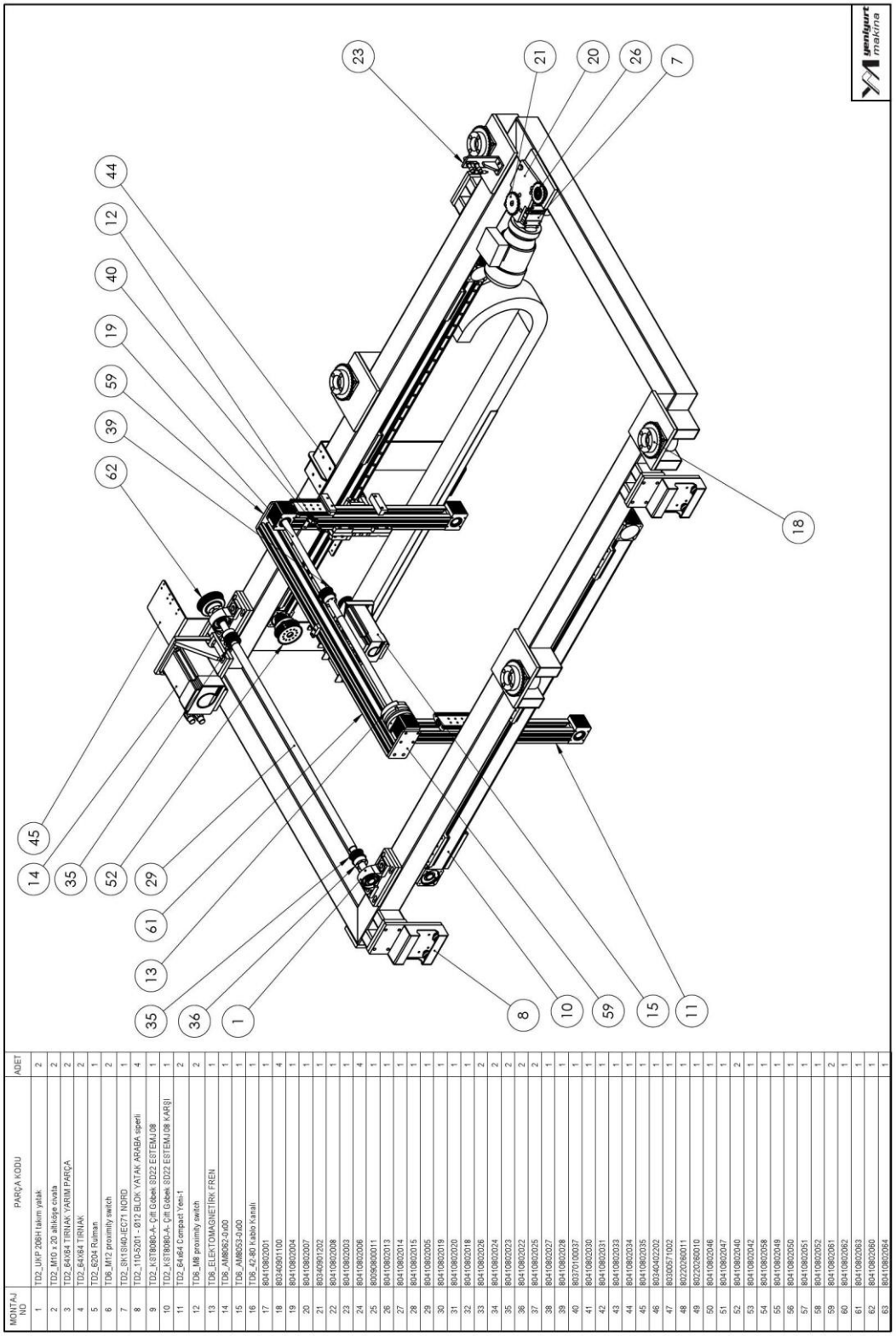


MONTAJ NO	PARÇA KODU	ADET
1	PNY 32 MIL	2
2	PNY ÇAP 32 ARKA KAPAK	2
3	32	2
4	PNY ÇAP 32 ÖN KAPAK	2
5	TD2_LME 30 UU Lineer Rulman	8
6	TD5_032 lik piston kasıntı alıcı	2
7	TD2_RCK 40 -25 x 50 x 17 Konik Göbek sıkma	1
8	TD2_k37_AQH_100-4_M8A (sew)	1
9	80340805005	1
10	80090800003	4
11	80410805002	2
12	80410805006	2
13	80340805004	1
14	80410805003	1
15	80220830006	1
16	80220831001	1
17	80220831002	1
18	80340805101	1
19	80300830009	4
20	80340805007	1
21	80340805008	2
22	80340805009	1

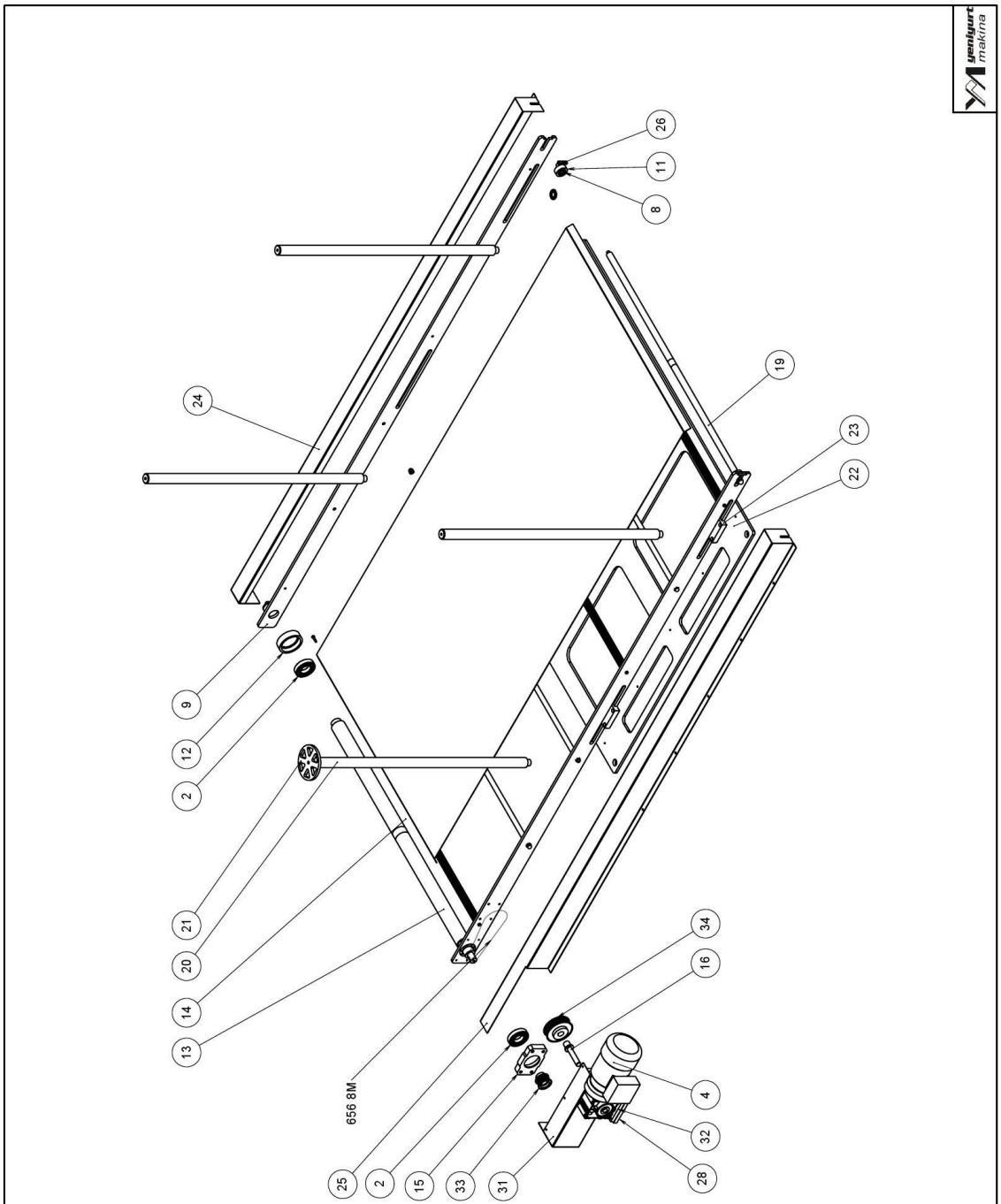


MONTAJ NO	PARÇA KODU	ADET
1	TD2_SK1SI63 NORD	1
2	TD2_3206 BTVH Eğik bilyalı Rulman	1
3	TD2_KM6 Manşon Somun	1
4	TD2_8x7x110 Kama	1
5	TD6_M8 proximity switch	1
6	80220841002	1
7	80220390003	1
8	80340806002	1
9	80410402701	1
10	80340806003	1
11	80300571002	1
12	80220260011	1
13	80220260010	1
14	80410402604	1
15	80410402702	1

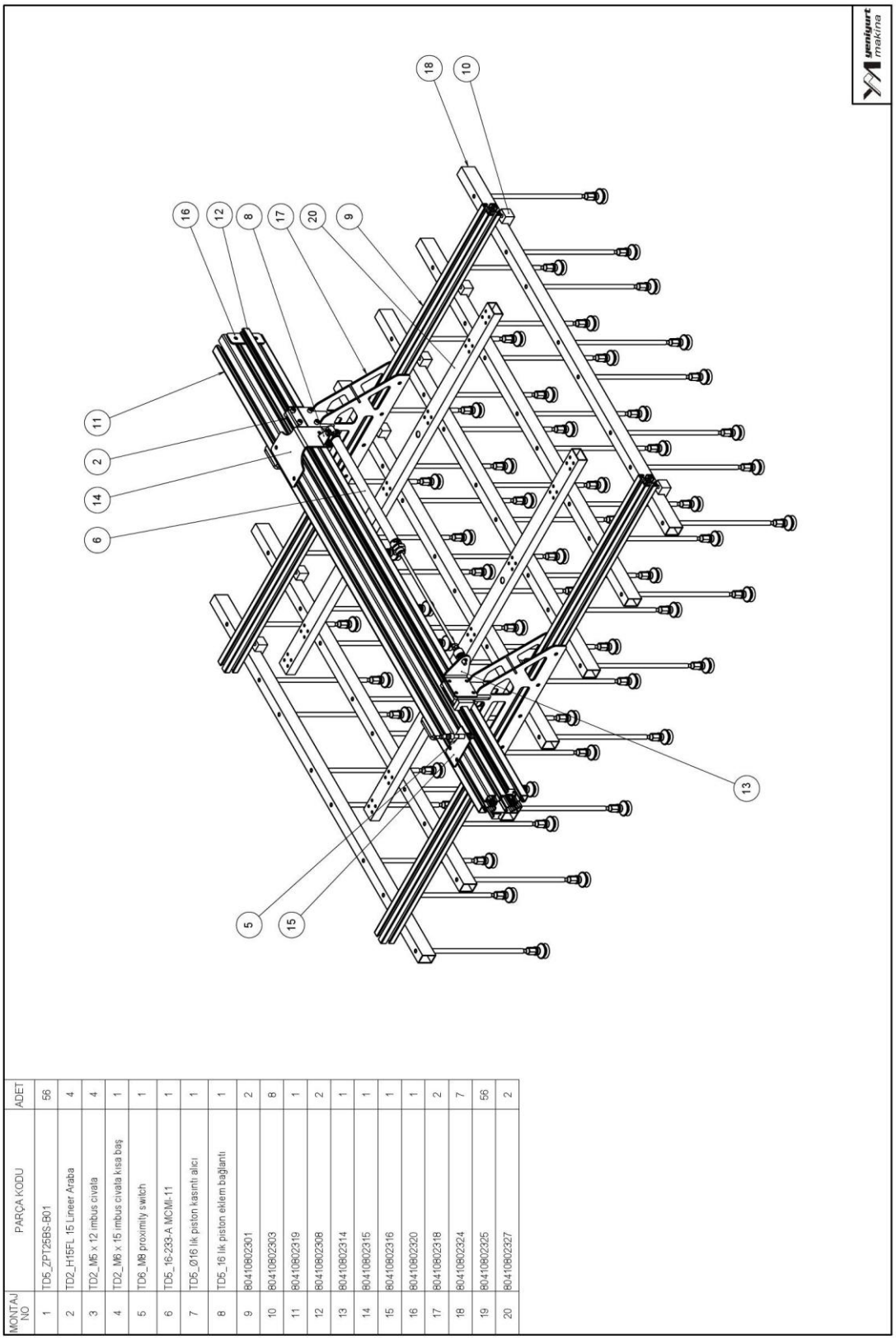
10.4 ROBOT STACKING SPARE PARTS LIST



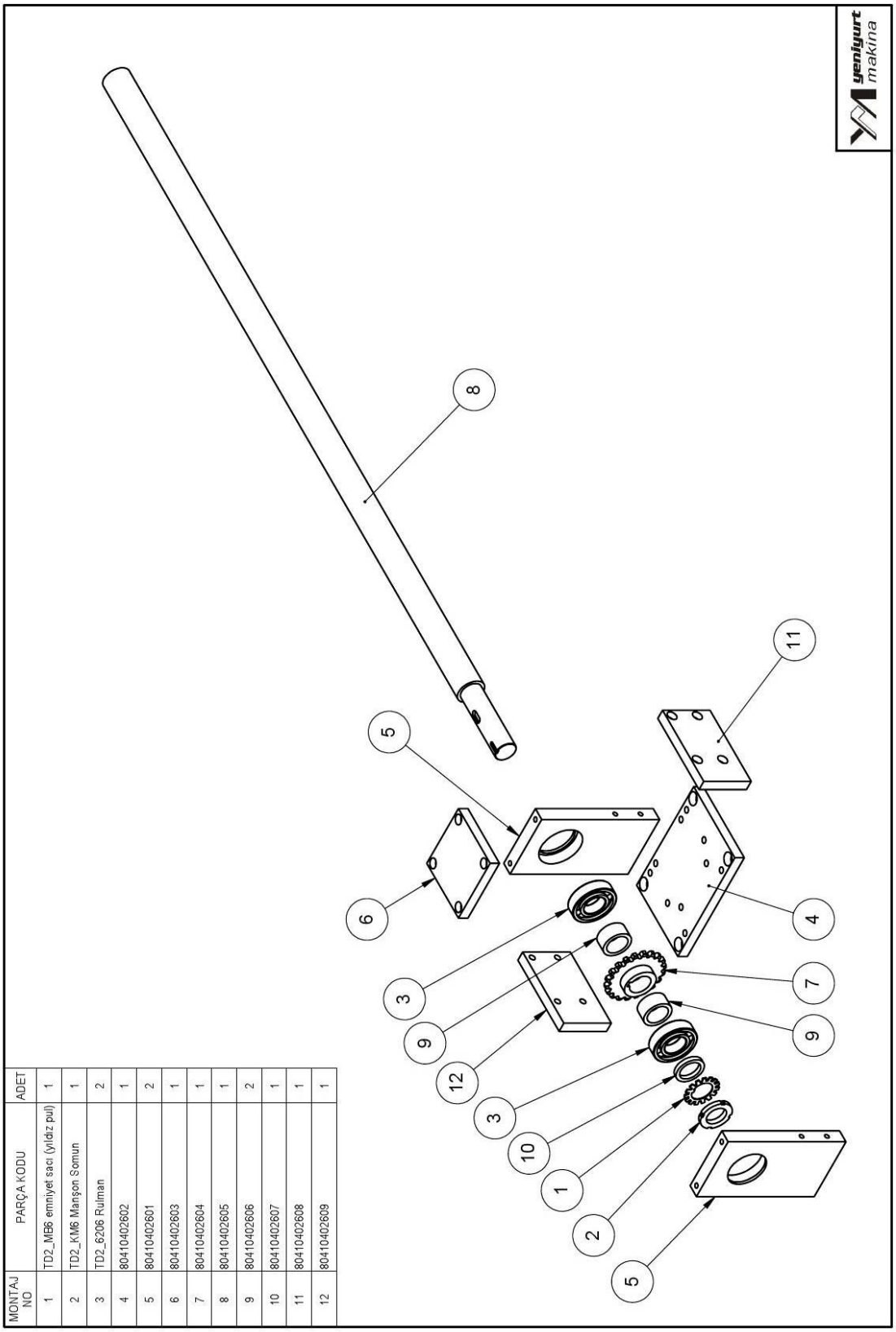
MONTAJ NO	PARÇA KODU	ADET
1	T02_UKP 206+I takım yatak	2
2	T02_M10 x 20 altıköşe civata	2
3	T02_64/64 TIRNAK YARIM PARÇA	2
4	T02_64/64 TIRNAK	2
5	T02_6204 Rulman	1
6	T06_M12 proximity switch	2
7	T02_SH1940-JEC71 NORD	1
8	T02_110-5201 - Ø12 BLOK YATAK ARABA şişeli	4
9	T02_KS180080-A- Çift Gidek S022 ESTEM Ø8	1
10	T02_KS180080-A- Çift Gidek S022 ESTEM Ø8 KARŞI	1
11	T02_64/64 Compact Yeni-1	2
12	T06_M8 proximity switch	2
13	T06_ELEKTOMAGNETİK FREN	1
14	T06_AM8082-6x60	1
15	T06_AM8053-6x60	1
16	T06_42-80 Kablo kanalı	1
17	80410802001	1
18	80340801100	4
19	80410802004	1
20	80410802007	1
21	80340901202	1
22	80410802008	1
23	80410802003	1
24	80410802006	4
25	80980800011	1
26	80410802013	1
27	80410802014	1
28	80410802015	1
29	80410802005	1
30	80410802019	1
31	80410802020	1
32	80410802018	1
33	80410802026	2
34	80410802024	2
35	80410802023	2
36	80410802022	2
37	80410802025	2
38	80410802027	1
39	80410802028	1
40	83370100037	1
41	80410802030	1
42	80410802031	1
43	80410802033	1
44	80410802034	1
45	80410802035	1
46	80340402202	1
47	80330571002	1
48	80220280011	1
49	80220280010	1
50	80410802046	1
51	80410802047	1
52	80410802040	2
53	80410802042	1
54	80410802058	1
55	80410802049	1
56	80410802050	1
57	80410802051	1
58	80410802052	1
59	80410802061	2
60	80410802062	1
61	80410802063	1
62	80410802060	1
63	80410802064	1



MONT AJ NO	PARÇA KODU	ADET
1	TD2_M6 x 25 altıköşe civata	6
2	TD2_1208 Oynak rulman	2
3	TD2_M12 pul	1
4	TD2_SK1S140-IEC71 NORD	1
5	TD2_KM5 manşon somun	4
6	TD2_M12 şapkalı somun	3
7	TD2_M10 şapkalı somun	6
8	TD2_1201 Oynak Bilyalı Rulman	2
9	B0410802101	1
10	B0410802102	1
11	B0300850023	2
12	B0410802118	1
13	B0410802106	1
14	B0410802107	1
15	B0410802115	1
16	B0410808429	1
17	B0410808404	3
18	B0410802108	3
19	B0410802105	1
20	B0410802111	4
21	B0340900003	1
22	B0410802109	1
23	B0410802110	4
24	B0410802112	1
25	B0410802114	1
26	B0410802113	2
27	B0410802119	1
28	B0410802120	1
29	B0410802122	1
30	B0410802121	3
31	B0410802123	1
32	B0410802125	1
33	B0410802126	1
34	B0410802127	1

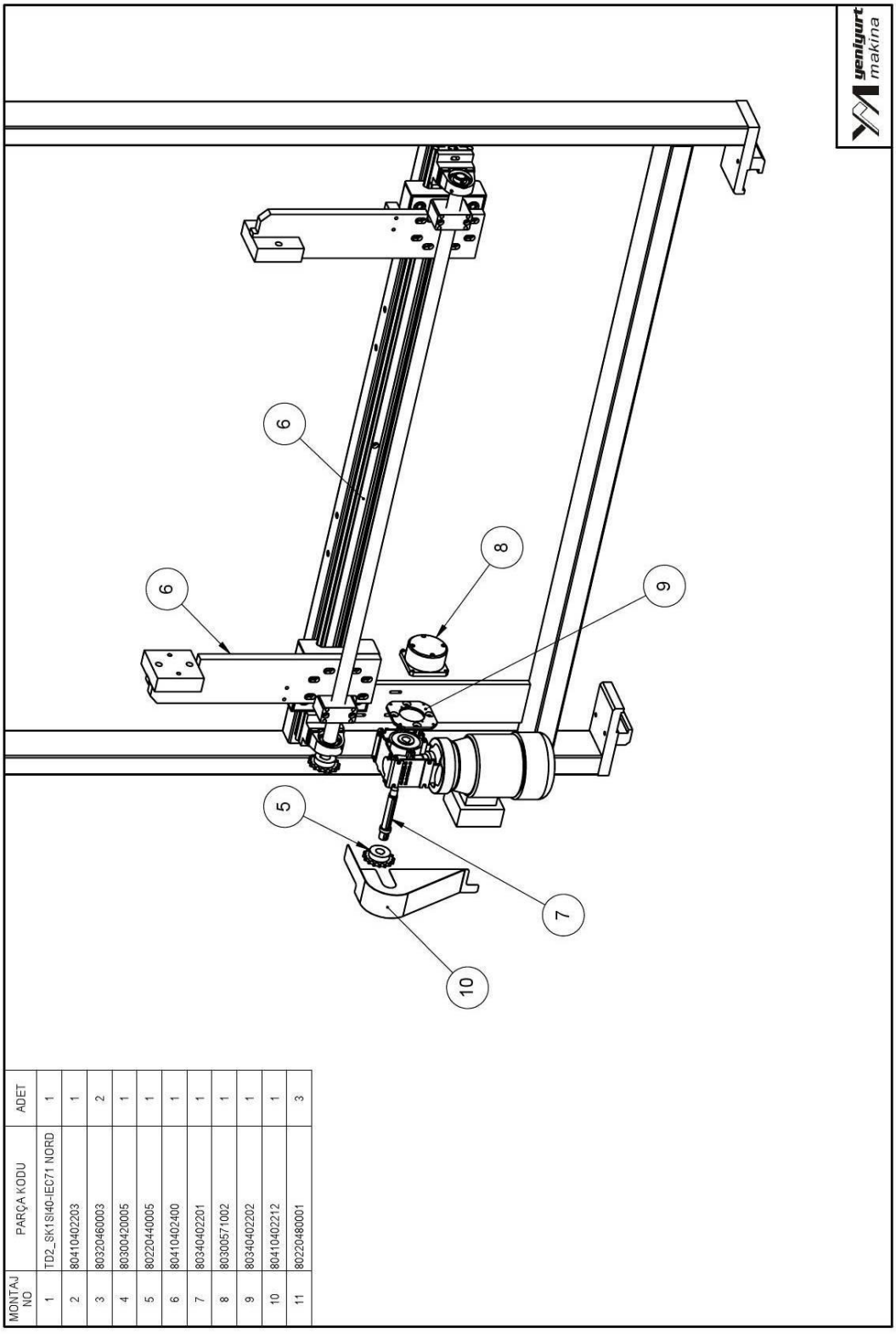


MONTAJ NO	PARÇA KODU	ADET
1	TD5_ZPT25BS-B01	56
2	TD2_H15FL 15 Lineer Araba	4
3	TD2_M5 x 12 imbus civata	4
4	TD2_M8 x 15 imbus civata kısa baş	1
5	TD6_M8 proximity switch	1
6	TD5_16-233-A MCMI-11	1
7	TD5_Ø16 lik piston kasıntı alıcı	1
8	TD5_16 lik piston eklem bağlantı	1
9	80410802301	2
10	80410802303	8
11	80410802319	1
12	80410802308	2
13	80410802314	1
14	80410802315	1
15	80410802316	1
16	80410802320	1
17	80410802318	2
18	80410802324	7
19	80410802325	56
20	80410802327	2



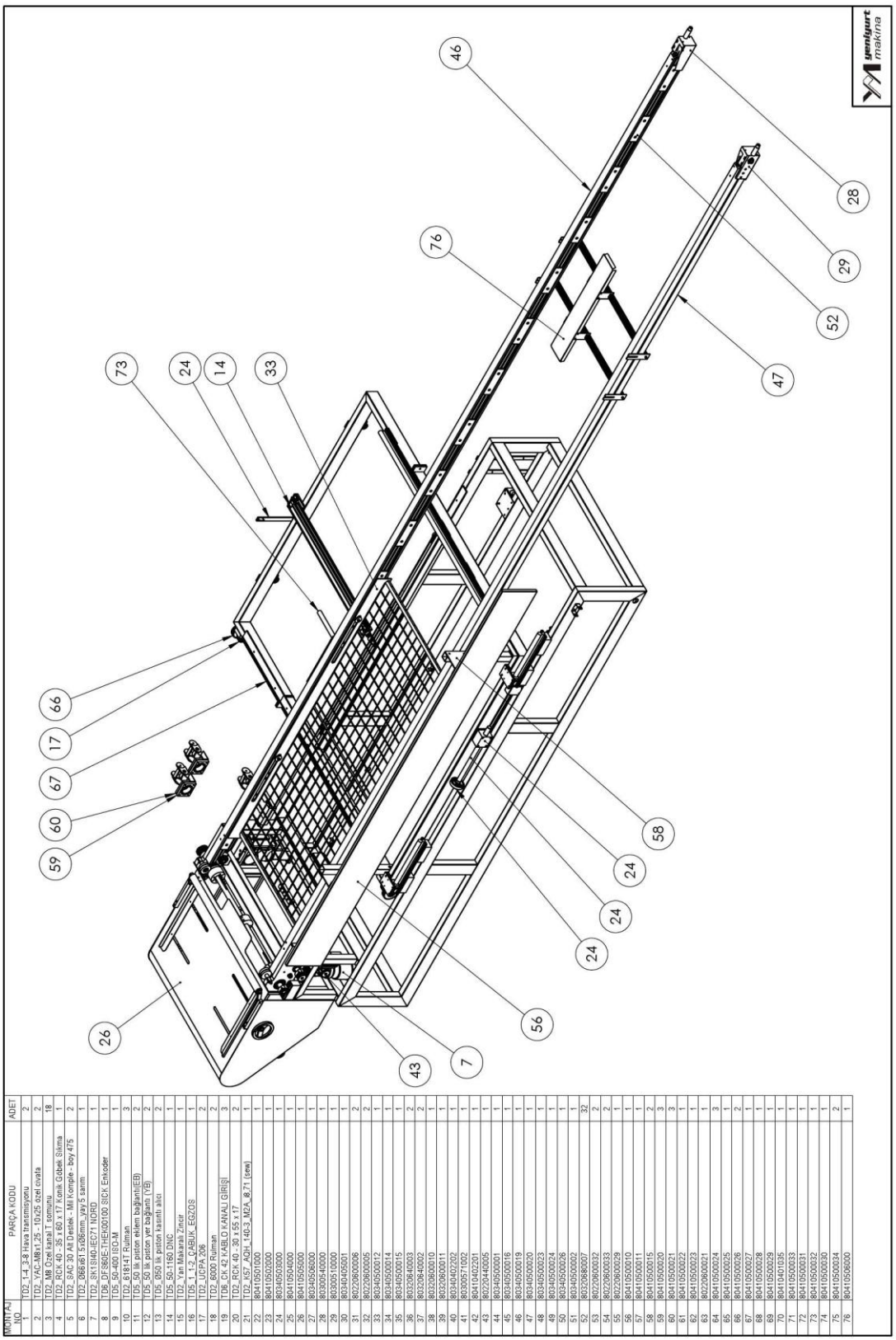
MONTAJ NO	PARÇA KODU	ADET
1	TD2_MB6 emniyet sacı (yıldız pul)	1
2	TD2_KM6 Manşon Somun	1
3	TD2_6206 Rulman	2
4	80410402602	1
5	80410402601	2
6	80410402603	1
7	80410402604	1
8	80410402605	1
9	80410402606	2
10	80410402607	1
11	80410402608	1
12	80410402609	1

10.5 STRETCHING SPARE PARTS LIST

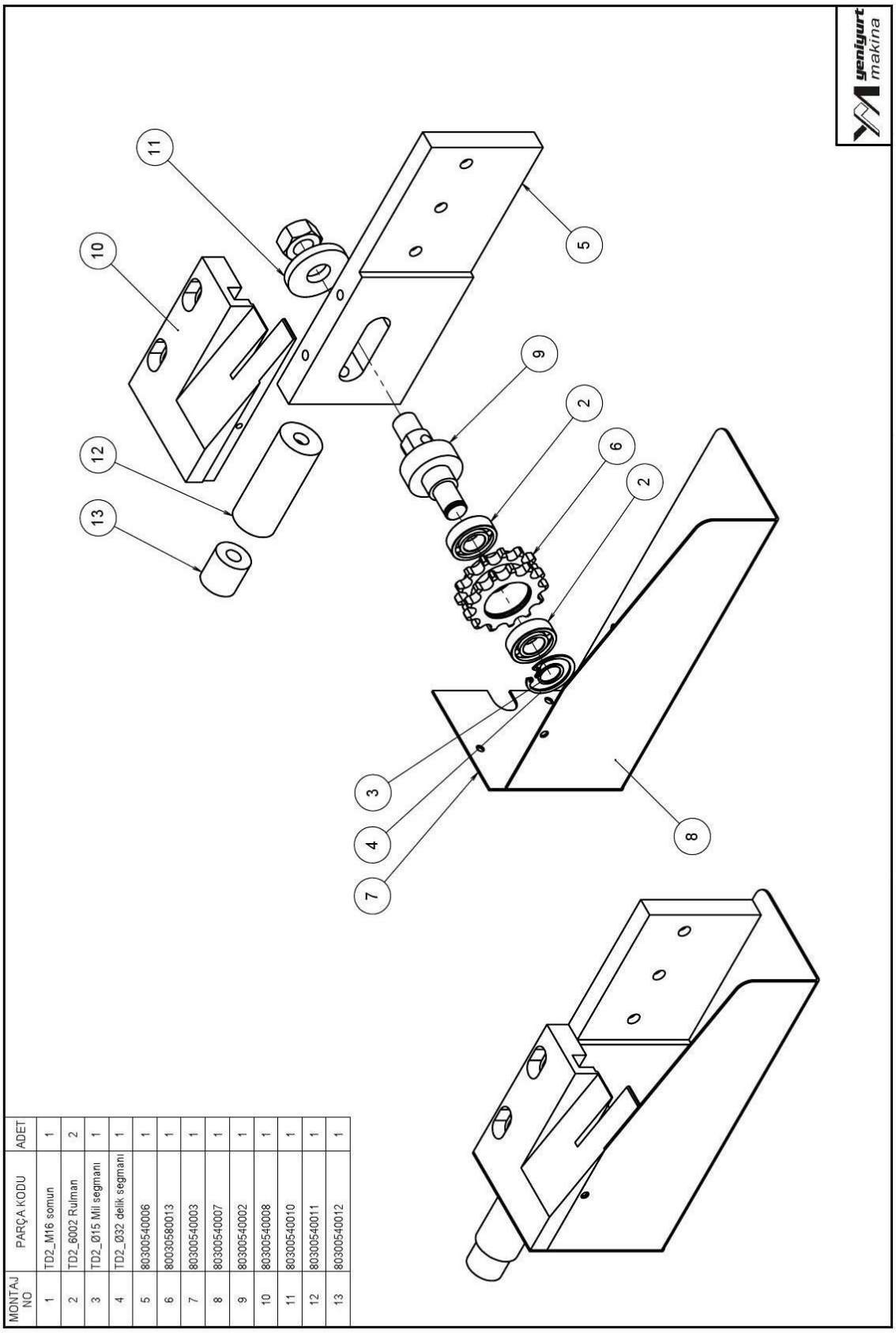


MONTAJ NO	PARÇA KODU	ADET
1	TD2_SK1SI40-IEC71 NORD	1
2	80410402203	1
3	80320460003	2
4	80300420005	1
5	80220440005	1
6	80410402400	1
7	80340402201	1
8	80300571002	1
9	80340402202	1
10	80410402212	1
11	80220480001	3

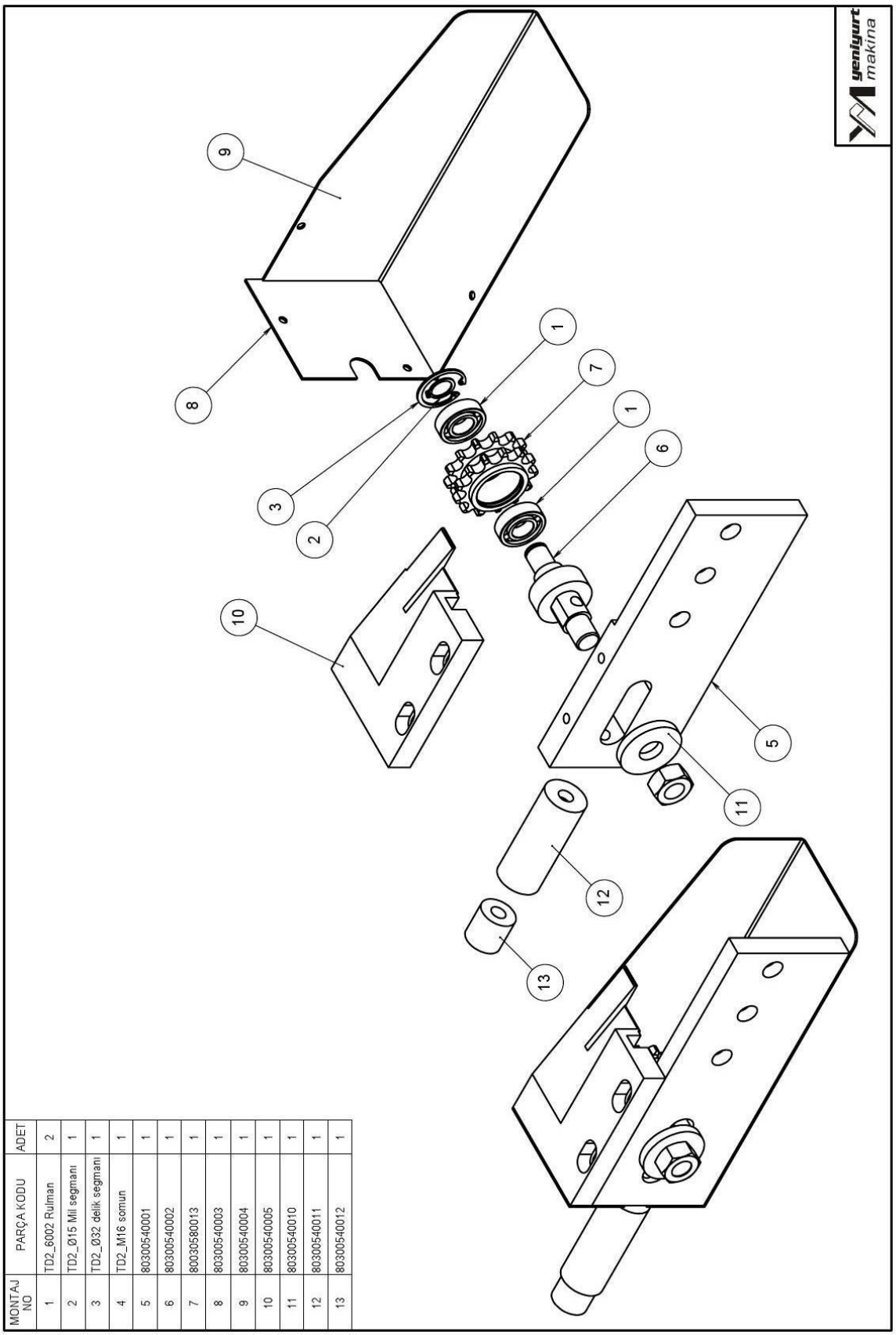
10.6 CHAIN SPARE PARTS LIST



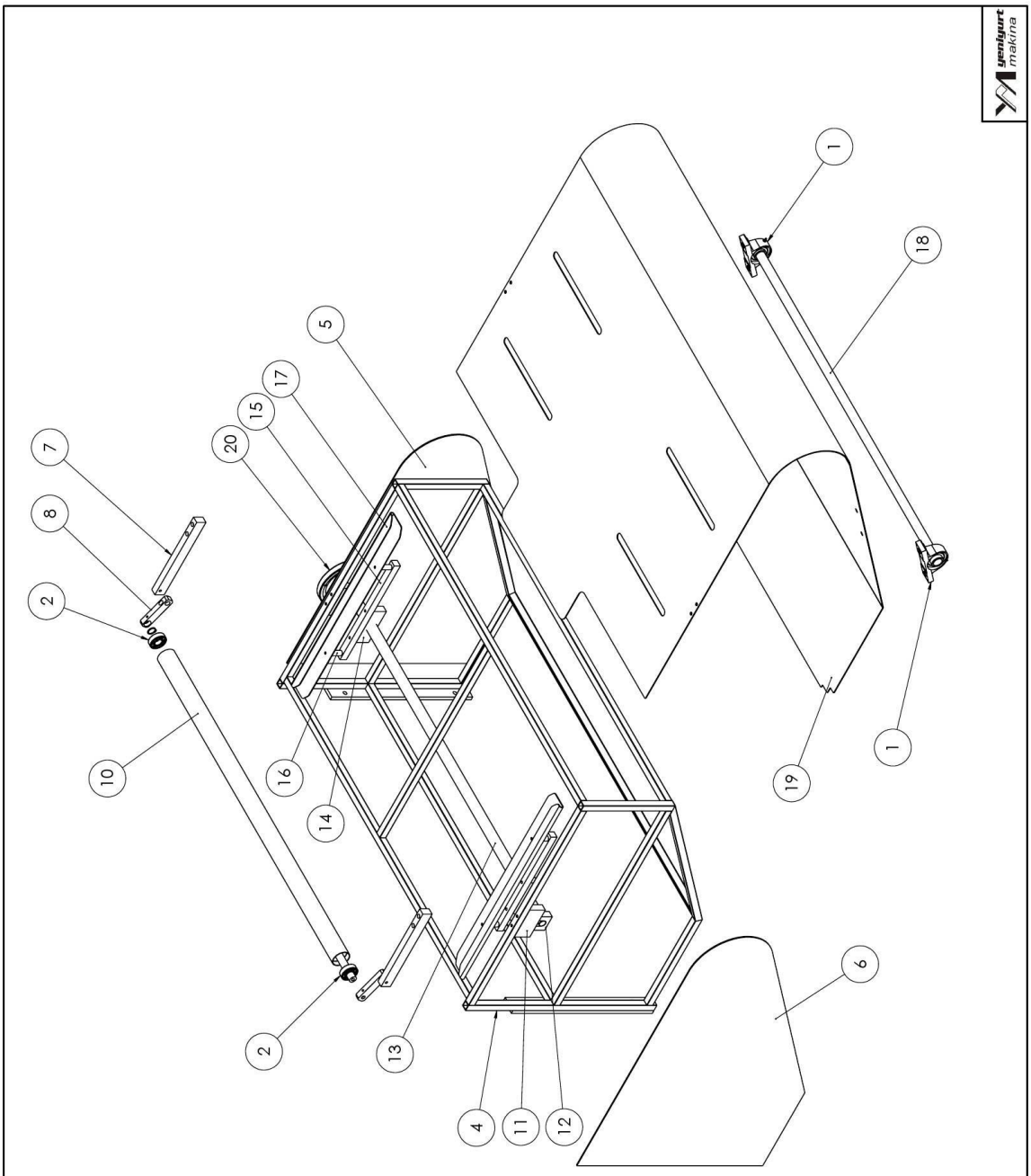
MONTAJ NO	PARÇA KODU	ADET
1	TD2_1-4_3,8 Hava hasetmiyonu	2
2	TD2_YAC-M8x1,25 - 10x25 özel civata	2
3	TD2_M8 Özel kanal T somunu	18
4	TD2_RCK 40 - 35 x 60 x 17 Konik Gobek Sikma	1
5	TD2_SAC 30 Ali Destek - Mil komple - boy 475	2
6	TD2_Ø66 ø61,5x86mm_yay 5 sarım	1
7	TD2_SK1SI4D-IEC71 NORD	1
8	TD6_DFS60E-THEH00100 SICK Enkoder	1
9	TD5_50-400 IBO-M	1
10	TD2_81814T Rulman	3
11	TD5_50 lik piston eklem bağlantı(EB)	2
12	TD5_50 lik piston yer bağlantı (YB)	2
13	TD5_Ø50 lik piston kasnlı alıcı	2
14	TD5_50-1160 DNC	1
15	TD2_Yan Makaralı Zincir	1
16	TD5_1_1-2_KAPAK_EGZOS	1
17	TD2_UCPA 206	2
18	TD2_8000 Rulman	2
19	TD6_CK 14 YOL KANALI GİRİŞİ	3
20	TD2_KS7_40-35_14	2
21	TD2_KS7_40-35_M25_8,71 (dew)	1
22	80410901000	1
23	80411502000	1
24	80340503000	1
25	80411504000	1
26	80411505000	1
27	80340506000	1
28	80300540000	1
29	80300510000	1
30	80340405001	2
31	80220600006	2
32	80220600005	1
33	80340500012	1
34	80340500014	1
35	80340500015	2
36	80320640003	2
37	80320640002	2
38	80320600010	1
39	80320600011	1
40	80340402202	1
41	80300571002	1
42	80410402201	1
43	80220440005	1
44	80340500001	1
45	80340500016	1
46	80340500019	1
47	80340500020	1
48	80340500023	1
49	80340500024	1
50	80340500026	1
51	80340500002	1
52	80320680007	32
53	80220600032	2
54	80220600033	2
55	80220600029	1
56	80411500010	1
57	80411500011	1
58	80411500015	2
59	80411500020	3
60	80411500021	3
61	80411500022	1
62	80411500023	1
63	80220600021	1
64	80411500024	3
65	80411500025	1
66	80411500026	2
67	80411500027	1
68	80411500028	1
69	80411500029	1
70	80411401035	1
71	80411500033	1
72	80411500031	1
73	80411500032	1
74	80411500030	1
75	80411500034	2
76	80411506000	1



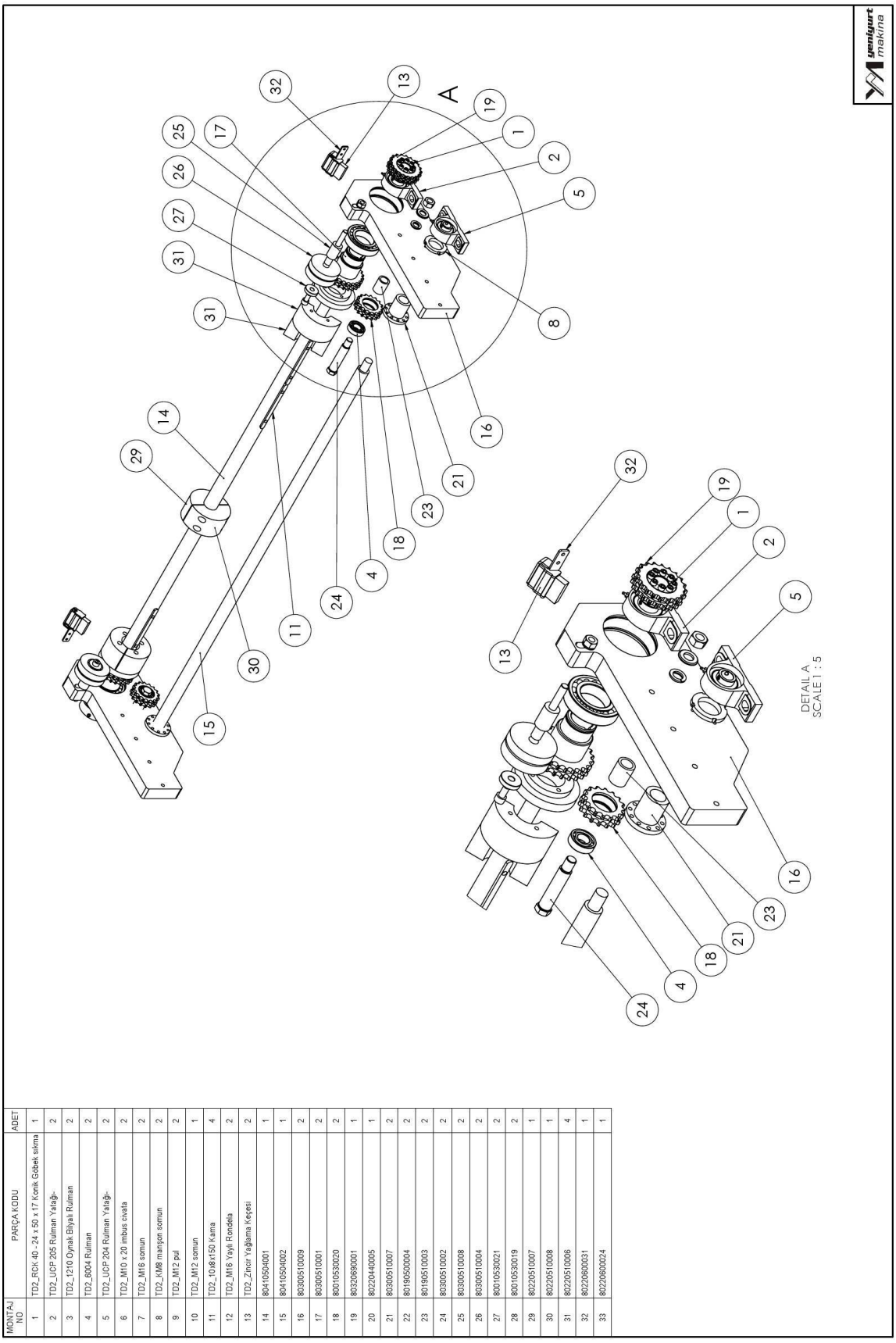
MONTAJ NO	PARÇA KODU	ADET
1	TD2_M16 somun	1
2	TD2_6002 Rulman	2
3	TD2_Ø15 Mil segmanı	1
4	TD2_Ø32 delik segmanı	1
5	80300540006	1
6	80030580013	1
7	80300540003	1
8	80300540007	1
9	80300540002	1
10	80300540008	1
11	80300540010	1
12	80300540011	1
13	80300540012	1



MONTAJ NO	PARÇA KODU	ADET
1	TD2_6002 Rulman	2
2	TD2_Ø15 Mil segmanı	1
3	TD2_Ø32 delik segmanı	1
4	TD2_M16 somun	1
5	80300540001	1
6	80300540002	1
7	80030580013	1
8	80300540003	1
9	80300540004	1
10	80300540005	1
11	80300540010	1
12	80300540011	1
13	80300540012	1

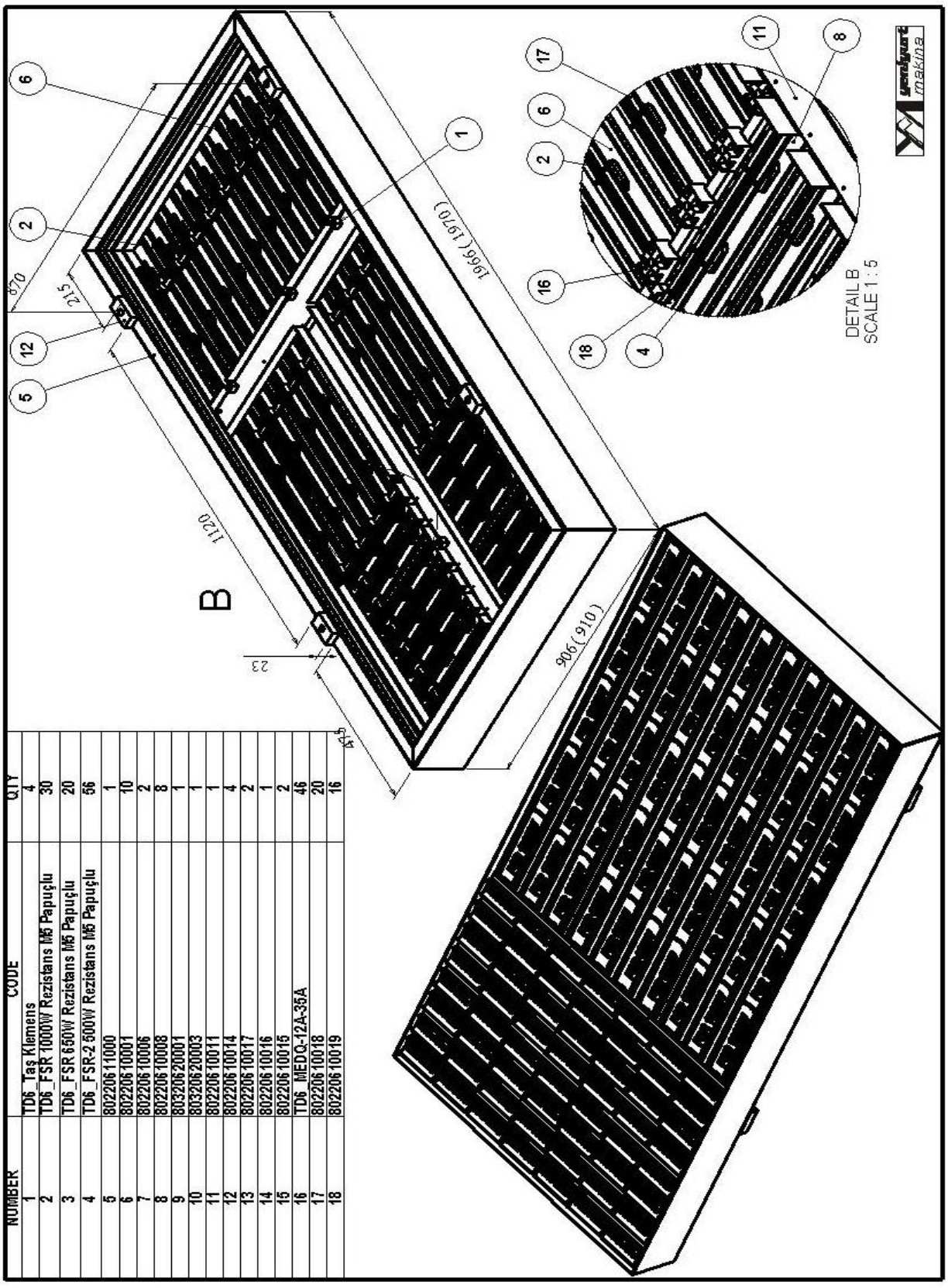


MONTAJ NO	PARÇA KODU	ADET
1	TD2_UCP 205 Rulman Yatağı	2
2	TD2_6204 Rulman	2
3	TD2_Ø20 Mil segmanı	2
4	80410505001	1
5	80220510009	1
6	80220510005	1
7	80190500007	2
8	80190500008	2
9	80410505102	1
10	80410505101	1
11	80220500074	2
12	80410505203	2
13	80410505201	1
14	80410505202	2
15	80120500071	2
16	80010560013	4
17	80090493008	2
18	80410505004	1
19	80410505003	1
20	80159510013	1

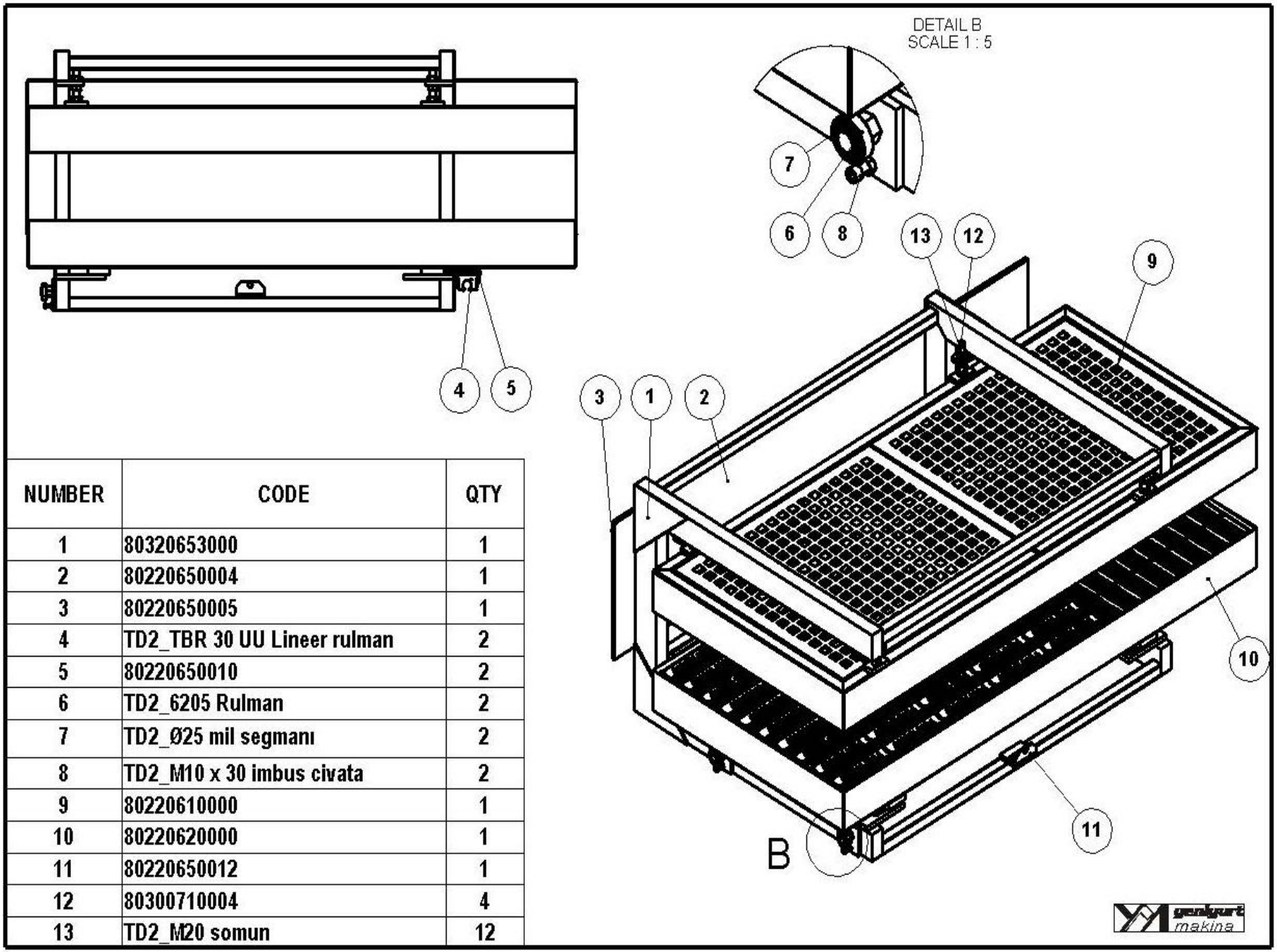


MONTAJ NO	PARÇA KODU	ADET
1	TD2_RCK 40 - 24 x 50 x 17 Konik Göbek sıkma	1
2	TD2_UCP 205 Rulman Yatağı-	2
3	TD2_1210 Oynak Bilyalı Rulman	2
4	TD2_6004 Rulman	2
5	TD2_UCP 204 Rulman Yatağı-	2
6	TD2_M10 x 20 imbus civata	2
7	TD2_M16 somun	2
8	TD2_KM8 manşon somun	2
9	TD2_M12 pul	2
10	TD2_M12 somun	1
11	TD2_10,8x150 Kama	4
12	TD2_M16 Yaylı Rondela	2
13	TD2_Zincir Yağlama Keçesi	2
14	80410504001	1
15	80410504002	1
16	80300510009	2
17	80300510001	2
18	80010530020	2
19	80320698001	1
20	80220440005	1
21	80300510007	2
22	80190500004	2
23	80190510003	2
24	80300510002	2
25	80300510008	2
26	80300510004	2
27	80010530021	2
28	80010530019	2
29	80220510007	1
30	80220510008	1
31	80220510006	4
32	80220600031	1
33	80220600024	1

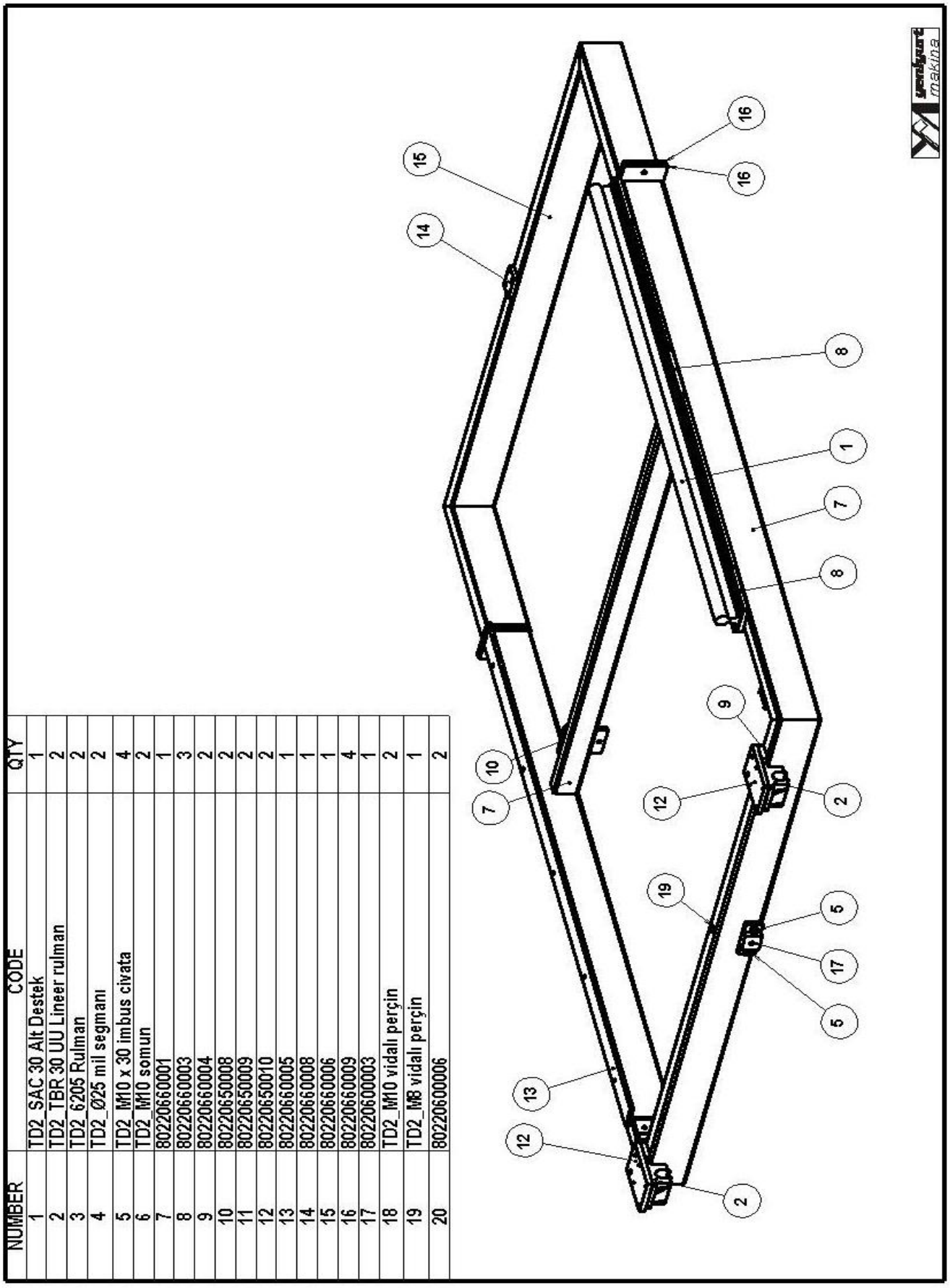
10.7 HEATER HEAT SPARE PARTS LIST



NUMBER	CODE	QTY
1	TD6_Taş Klemens	4
2	TD6_FSR 1000W Rezistans M5 Papuçlu	30
3	TD6_FSR 650W Rezistans M5 Papuçlu	20
4	TD6_FSR-2 500W Rezistans M5 Papuçlu	56
5	802206 11000	1
6	802206 10001	10
7	802206 10006	2
8	802206 10008	8
9	803206 20001	1
10	803206 20003	1
11	802206 10011	1
12	802206 10014	4
13	802206 10017	2
14	802206 10016	1
15	802206 10015	2
16	TD6_MEDQ-12A-35A	46
17	802206 10018	20
18	802206 10019	16

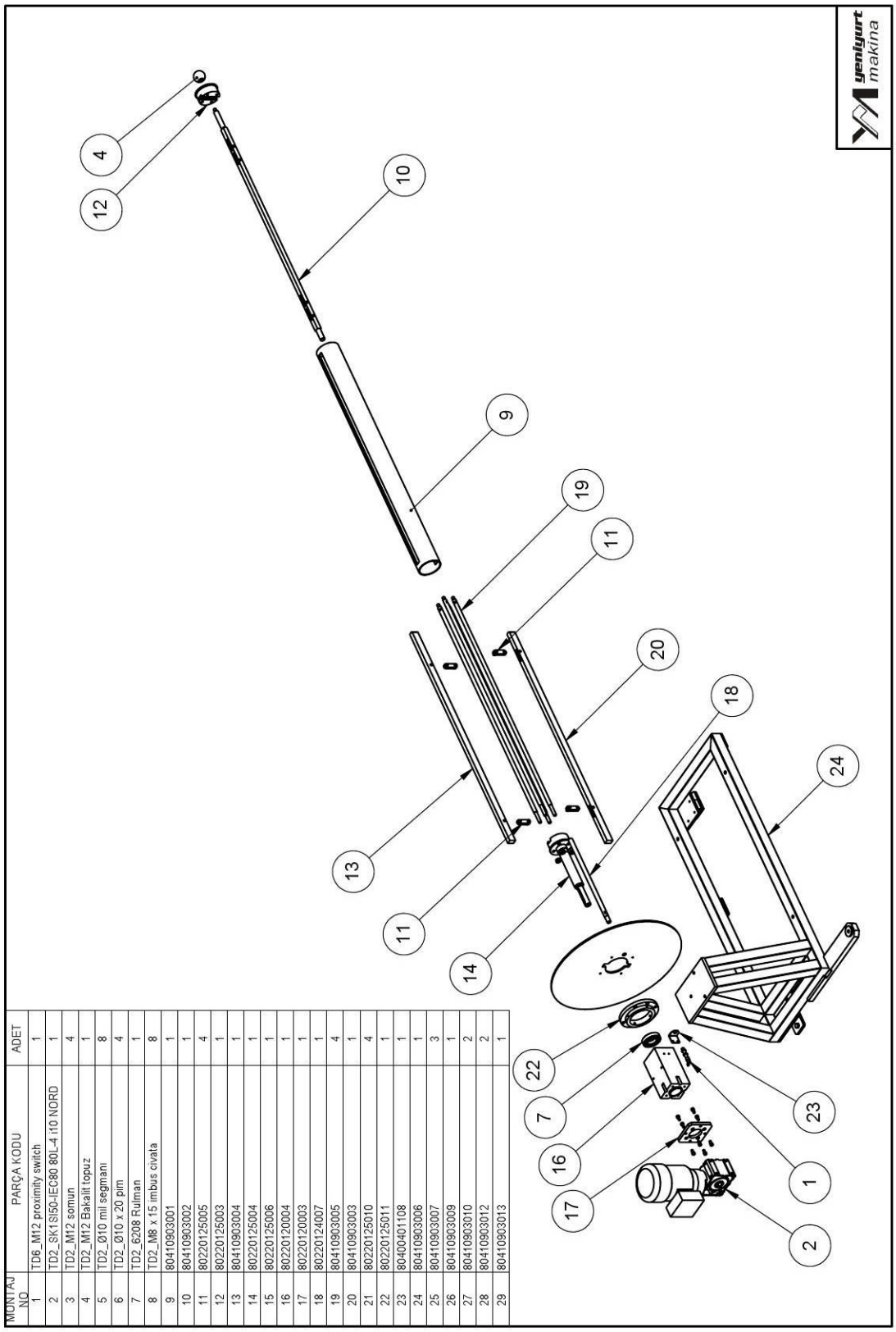


NUMBER	CODE	QTY
1	80320653000	1
2	80220650004	1
3	80220650005	1
4	TD2_TBR 30 UU Lineer rulman	2
5	80220650010	2
6	TD2_6205 Rulman	2
7	TD2_Ø25 mil segmanı	2
8	TD2_M10 x 30 imbus civata	2
9	80220610000	1
10	80220620000	1
11	80220650012	1
12	80300710004	4
13	TD2_M20 somun	12



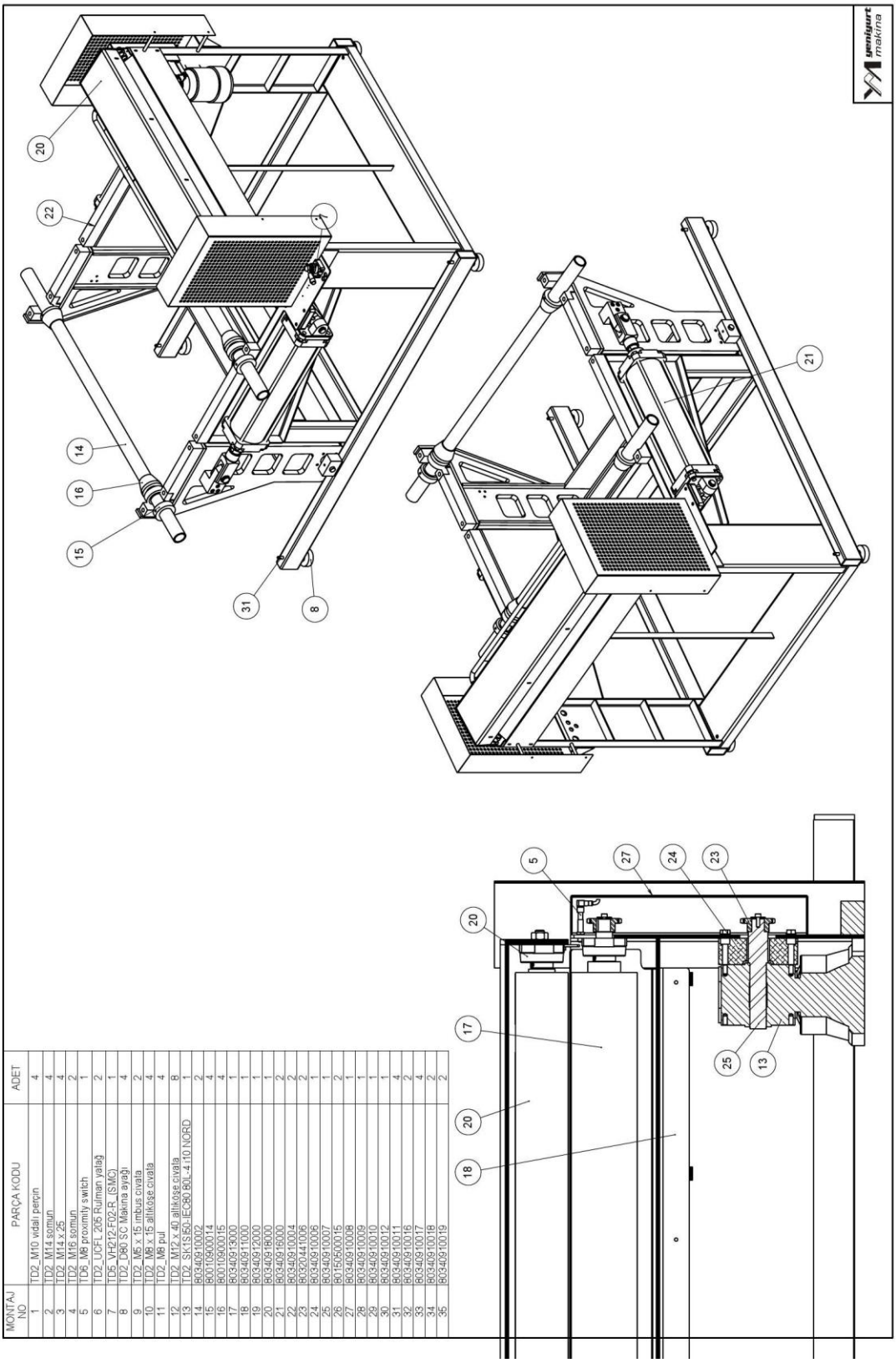
NUMBER	CODE	QTY
1	TD2_SAC 30 Alt Destek	1
2	TD2_TBR 30 UU Lineer rulman	2
3	TD2_6205 Rulman	2
4	TD2_Ø25 mil segmanı	2
5	TD2_M10 x 30 imbus civata	4
6	TD2_M10 somun	2
7	8022060001	1
8	8022060003	3
9	8022060004	2
10	8022050008	2
11	8022050009	2
12	8022050010	2
13	8022060005	1
14	8022060008	1
15	8022060006	1
16	8022060009	4
17	8022060003	1
18	TD2_M10 vidalı perçin	2
19	TD2_M8 vidalı perçin	1
20	8022060006	2

10.8 WRAPPER SPARE PARTS LIST

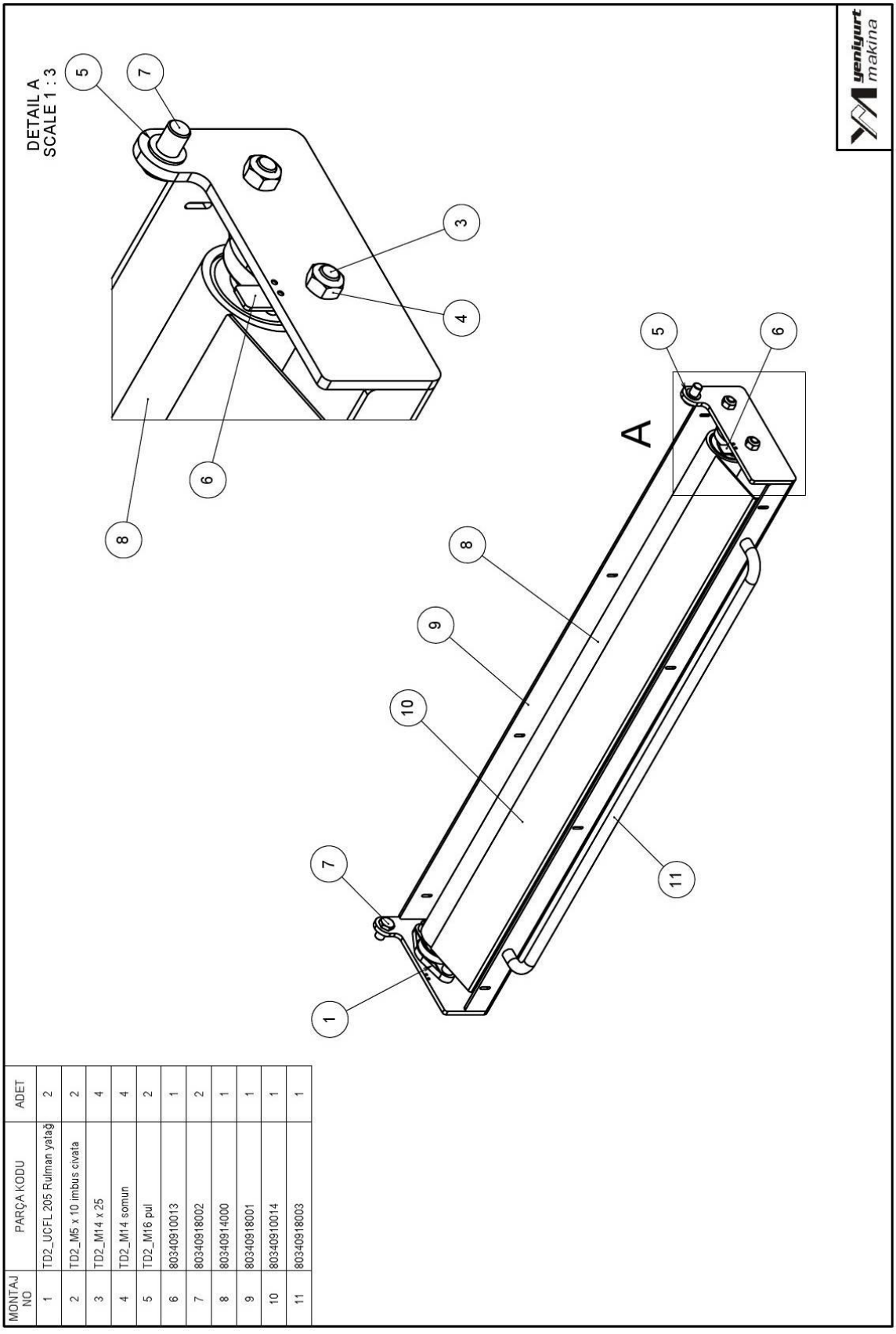


MONTAJ NO	PARÇA KODU	ADET
1	TD6_M12 proximity switch	1
2	TD2_SK1SI50-IEC80 80L-4 i10 NORD	1
3	TD2_M12 somun	4
4	TD2_M12 Bakalit topuz	1
5	TD2_Ø10 mil segmanı	8
6	TD2_Ø10 x 20 pim	4
7	TD2_6208 Rulman	1
8	TD2_M8 x 15 imbus civata	8
9	80410903001	1
10	80410903002	1
11	80220125005	4
12	80220125003	1
13	80410903004	1
14	80220125004	1
15	80220125006	1
16	80220120004	1
17	80220120003	1
18	80220124007	1
19	80410903005	4
20	80410903003	1
21	80220125010	4
22	80220125011	1
23	80400401108	1
24	80410903006	1
25	80410903007	3
26	80410903009	1
27	80410903010	2
28	80410903012	2
29	80410903013	1

10.9 UNWINDER SPARE PARTS LİST



MONTAJ NO	PARÇA KODU	ADET
1	TD2_M10 vidalı perçin	4
2	TD2_M14 somun	4
3	TD2_M14 x 25	4
4	TD2_M16 somun	2
5	TD6_M8 proximity switch	1
6	TD2_UCFL 205 Rulman yatağı	2
7	TD5_VHZ12-F02-R (SMC)	1
8	TD2_D80 SC Makina ayağı	4
9	TD2_M5 x 15 imbus civata	2
10	TD2_M8 x 15 altıköşe civata	4
11	TD2_M8 pul	4
12	TD2_M12 x 40 altıköşe civata	8
13	TD2_SK1S150_IEC80 B0L-4 110 NORD	1
14	R0340910002	2
15	R0010900014	4
16	R0010900015	4
17	R0340913000	1
18	R0340911000	1
19	R0340912000	1
20	R0340918000	1
21	R0340916000	2
22	R0340910004	2
23	R0320441006	2
24	R0340910006	1
25	R0340910007	1
26	R0150500015	2
27	R0340910008	1
28	R0340910009	1
29	R0340910010	1
30	R0340910012	1
31	R0340910011	4
32	R0340910016	2
33	R0340910017	4
34	R0340910018	2
35	R0340910019	2



MONTAJ NO	PARÇA KODU	ADET
1	TD2_UCFL 205 Rulman yatağ	2
2	TD2_M5 x 10 imbus civata	2
3	TD2_M14 x 25	4
4	TD2_M14 somun	4
5	TD2_M16 pul	2
6	80340910013	1
7	80340918002	2
8	80340914000	1
9	80340918001	1
10	80340910014	1
11	80340918003	1

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